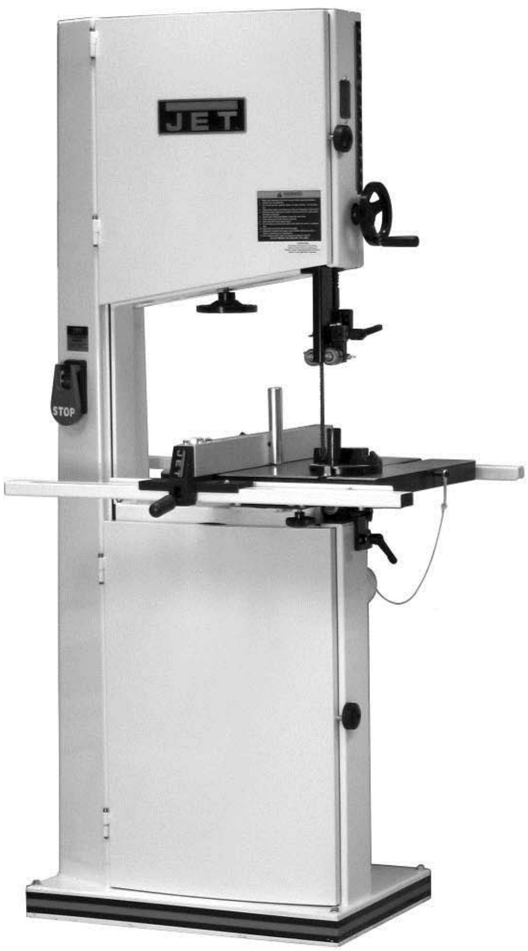
Operating Instructions and Parts Manual
18-Inch, 20-Inch Band Saw
Models: JWBS-18QT, -18QT-3, -20QT-3, -20QT-5


JWBS-18QT


JWBS-20QT

JET
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Part No. M-710750B
Revision C1 01/2014

Warranty and Service

JET, Wilton and Powermatic warrants every product they sell against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday

Warranty Period
The general warranty lasts for the time period specified in the literature included with your product or on the official JET, Wilton or Powermatic branded websites.

- JET, Wilton and Powermatic products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered
This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered
This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance.

Warranty Limitations
Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support
Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET, Wilton and Powermatic have Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET, Wilton or Powermatic website.

More Information
JET, Wilton and Powermatic are consistently adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET, Wilton or Powermatic website.

How State Law Applies
This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty
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Product Listing with Warranty Period

Product Listing with Warranty Period
90 Days – Parts; Consumable items; Light-Duty Air Tools
1 Year – Motors; Machine Accessories; Heavy-Duty Air Tools; Pro-Duty Air Tools
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories
5 Year – Woodworking Machinery
Limited Lifetime – Wilton branded products; JET Parallel clamps; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools

NOTE: JET, Wilton and Powermatic are divisions of JPW Industries, Inc.. References in this document to JET, Wilton and/or Powermatic also apply to JPW Industries, Inc., or any of its successors in interest to the JET, Wilton and/or Powermatic brands.

Table of Contents

⚠ Warnings

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace the warning labels if they become obscured or removed.
4. This band saw is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a band saw, do not use until proper training and knowledge have been obtained.
5. Do not use this band saw for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear approved safety glasses/face shields while using this band saw. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
7. Before operating this band saw, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
8. Wear ear protectors (plugs or muffs) during extended periods of operation.
9. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contain chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead based paint.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.

10. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
11. Make certain the switch is in the OFF position before connecting the machine to the power supply.
12. Make certain the machine is properly grounded.
13. Make all machine adjustments or maintenance with the machine unplugged from the power source.
14. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
15. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately.
16. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
17. Provide for adequate space surrounding work area and non-glare, overhead lighting.
18. Keep the floor around the machine clean and free of scrap material, oil and grease.
19. Keep visitors a safe distance from the work area. **Keep children away.**

⚠ Warnings

20. Make your workshop child proof with padlocks, master switches or by removing starter keys.
21. Give your work undivided attention. Looking around, carrying on a conversation and “horse-play” are careless acts that can result in serious injury.
22. Maintain a balanced stance at all times so that you do not fall or lean against the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
23. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and safer.
24. Use recommended accessories; improper accessories may be hazardous.
25. Maintain tools with care. Keep blades sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
26. Turn off the machine before cleaning. Use a brush or compressed air to remove chips or debris — do not use your hands.
27. Do not stand on the machine. Serious injury could occur if the machine tips over.
28. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
29. Remove loose items and unnecessary work pieces from the area before starting the machine.

Familiarize yourself with the following safety notices used in this manual:

⚠CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠WARNING This means that if precautions are not heeded, it may result in serious injury or possibly even death.

- - SAVE THESE INSTRUCTIONS - -

Introduction

This manual is provided by JET covering the safe operation and maintenance procedures for JET model JWBS-18QT and JWBS-20QT series band saws. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. This machine has been designed and constructed to provide years of trouble free operation if used in accordance with instructions set forth in this manual. If there are any questions or comments, please contact either your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

Specifications

Model Number	**JWBS-18QT**	**JWBS-18QT-3**	**JWBS-20QT-3**	**JWBS-20QT-5**
Stock Number	710750B	710751B	708754B	708755B
Band Saw Nominal Size (in.)	18	18	20	20
Capacities and Speeds:				
Cutting Capacity (height) (in.)	12	12	12-1/4	12-1/4
Cutting Capacity (width) (in.)	18-3/8	18-3/8	20	20
Maximum Rip Left of Blade w/Fence (in.)	16-1/2	16-1/2	18-1/2	18-1/2
Maximum Rip Right of Blade w/Fence (in.)	7-5/8	7-5/8	9-3/4	9-3/4
Blade Length (in.)	137	137	150	150
Blade Speed (FPM)	1800/3200	1800/3200	1800/3200	1800/3200
Blade provided	hook, 3/4” x 4 TPI	hook, 3/4” x 4 TPI	hook, 1” x 3 TPI	hook, 1” x 3 TPI
Minimum Blade Width (in.)	1/8	1/8	1/8	1/8
Maximum Blade Width (in.)	1-1/2	1-1/2	1-1/2	1-1/2
Wheel Diameter (in.)	18-5/8	18-5/8	20-1/2	20-1/2
Table and Fence:				
Table Size (in.)	19” x 19”	19” x 19”	21" x 21"	21" x 21"
Table Tilt (degrees)	45°R to 10°L	45°R to 10°L	45°R to 10°L	45°R to 10°L
Table Height from Floor (in.)	37-1/2	37-1/2	36-1/8	36-1/8
Fence Size (LxWxH/in.)	23-5/8x1-3/4x3-1/2	23-5/8x1-3/4x3-1/2	23-5/8x1-3/4x3-1/2	23-5/8x1-3/4x3-1/2
Resaw post (LxDia./in.)	6 x 1-1/8	6 x 1-1/8	6 x 1-1/8	6 x 1-1/8
Dust Collection:				
Dust Port Outside Diameter (in.)	4	4	4	4
Minimum Extraction Volume Required (CFM)	400	400	400	400
Overall Dimensions (HxWxD/in.)	73 x 41-1/2 x 30	73 x 41-1/2 x 32	74 x 41-1/2 x 37	74 x 41-1/2 x 39
Motor and Electricals:				
Motor	1.75HP(1.3kW), 1PH 115/230V[1], 17.6/8.8A, 60Hz	3HP(2.2kW), 1PH 230V, 13A, 60Hz	3HP(2.2kW), 1PH 230V, 13A, 60Hz	5HP(3.7kW), 1PH 230V, 21A, 60Hz
Start Capacitor	300MFD 125VAC	300MFD 125VAC	300MFD 125VAC	300MFD 250VAC
Run Capacitor	40µF 250VAC	60µF 250VAC	60µF 250VAC	50µF 450VAC
Power transfer	poly-V belt	poly-V belt	poly-V belt	poly-V belt
Power plug included	yes	no	no	no
Recommended circuit size[2]	40A/20A	30A	30A	50A
Weights:				
Net Weight (lbs.)	375	381	562	595
Shipping Weight (lbs.)	452	459	643	676

[1] Prewired 115V
[2] Subject to local and national electrical codes.

The above specifications were current at the time this manual was published, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

Grounding Instructions

⚠WARNING This machine must be grounded while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor, with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded. Use only three wire extension cords that have three-prong grounding plugs and three-pole receptacles that accept the tool's plug.

Repair or replace a damaged or worn cord immediately.

Model JWBS-18QT

Model JWBS-18QT Band Saw has a 1-3/4 HP 1 phase motor and is wired from the factory for 115 volt operation, but can be rewired for 220 volts.

115 Volt Operation

The JWBS-18QT Band Saw comes equipped with a *plug* that looks like A, Fig. 1. and is used in an *outlet* that looks like B, Fig. 1. A *temporary adapter* with a *grounding ear* secured with a *screw* (C, Fig. 1) may be used to connect this plug to a two-pole receptacle if a properly grounded outlet is not available. The temporary adapter should only be used until a properly grounded outlet can be installed by a qualified electrician. **This adapter is not applicable in Canada.** The green colored *grounding ear*, lug, or tab, extending from the adapter, must be connected to a permanent ground such as a properly grounded outlet box, as shown in C, Fig. 1.

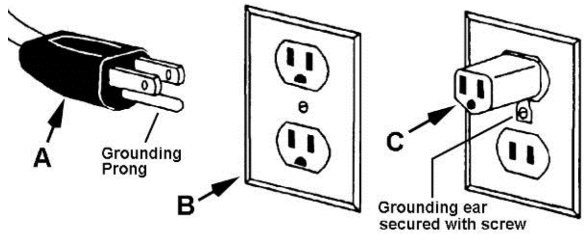


Figure 1

230 Volt Operation

To convert the JWBS-18QT from 115V to 230V, single phase operation, the following is strongly recommended:

Contact your local Authorized JET Service Center or qualified electrician for proper procedures to install the plug. The band saw must comply with all local and national codes after the 230V plug is installed.

Change the lead wires at the motor junction box as shown in B, Figure 2.

The 115V attachment plug supplied with the band saw (C, Fig. 2) must be replaced with a UL/CSA listed plug suitable for 230V operation (D, Fig. 2).

The band saw with a 230V plug should only be connected to an outlet having the same configuration (D, Fig. 2). No adapter is available or should be used with the 230V plug.

Important: In all cases (115 or 230 volts), make certain the receptacle in question is properly grounded. If you are not sure, have a registered electrician check the receptacle.

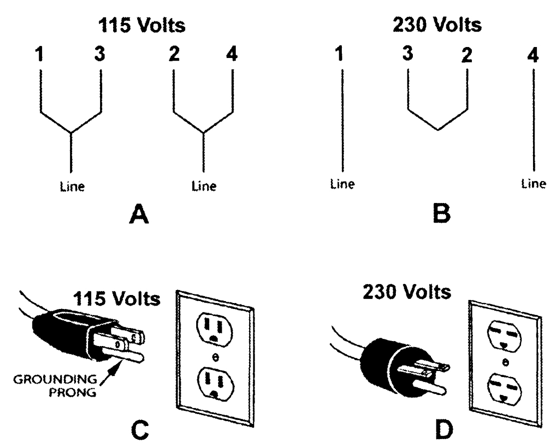


Figure 2

Models JWBS-18-3, -20QT-3, -20QT-5

Band saw models JWBS-18QT-3, JWBS-20QT-3 and JWBS-20QT-5 are wired from the factory for 230 volt operation only. Refer to *Specifications* for phase and HP ratings.

A plug is not included. You may either install a plug or "hard-wire" the band saw directly to a control panel.

If connecting a plug, use a proper UL/CSA listed 2-pole, 3-wire grounding plug suitable for 230V operation.

If the band saw is to be hard-wired to a panel, make sure a disconnect is available for the operator. During hard-wiring of the band saw, make sure the fuses have been removed or the breakers have been tripped in the circuit to which the band saw will be connected. Place a warning placard on the fuse holder or circuit breaker to prevent it being turned on while the machine is being wired.

Circuit Information

The Band Saw should be connected to a dedicated circuit with a circuit breaker or time delay fuse with the appropriate amperage rating. See Table 1 for recommended circuit sizes. *NOTE: These are recommendations only – all local codes must be given priority.*

Extension cords

The use of an extension cord is not recommended for this band saw. Try to position your machine within reach of the power supply. If an extension cord becomes necessary, make sure the cord rating is suitable for the amperage listed on the machine's motor plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

Use the chart in Table 2 as a general guide in choosing the correct size cord. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Model	Voltage	Recommended Circuit*
JWBS-18QT **710750B**	115V	40A
	230V	20A
JWBS-18QT-3 **710751B**	230	30A
JWBS-20QT-3 **708754B**	230	30A
JWBS-20QT-5 **708755B**	230	50A

*** Local codes take precedence over recommendations.**

Table 1

Recommended Gauges (AWG) of Extension Cords

Amps	Extension Cord Length *					
	25 feet	50 feet	75 feet	100 feet	150 feet	200 feet
< 5	16	16	16	14	12	12
5 to 8	16	16	14	12	10	NR
8 to 12	14	14	12	10	NR	NR
12 to 15	12	12	10	10	NR	NR
15 to 20	10	10	10	NR	NR	NR
21 to 30	10	NR	NR	NR	NR	NR

*based on limiting the line voltage drop to 5V at 150% of the rated amperes.
NR: Not Recommended.

Table 2

Unpacking

Remove the crate and packing material from the band saw except for the transport skid on the bottom. Inspect the machine for damage. Report any damage to your distributor and shipping agent.

Move the saw to its permanent working location. The site should be dry, well lit, and have enough room to handle long stock and the service and/or adjustment of the machine from any side.

Move the band saw off the skid. Clean all rust protected surfaces with a mild solvent or diesel fuel and a soft cloth. Do not use lacquer thinner, paint thinner, or gasoline. These will damage painted surfaces.

Contents of Shipping Container

1 Band Saw (not shown)
1 Rail Guide (A)
1 Rear Rail (B)
1 Front Rail (C)
1 Fence Body (D)
1 Miter Gauge (E)
1 Fence (F)
1 Table (G)

1 Accessory Package Contains:
Hardware Bag
  1 Resaw Post (H)
  1 10/12mm Open End Wrench (J)
  1 Handle (K)
  1 Lock Handle (L) – JWBS-20QT only
  1 Resaw Post Lock Knob (M)
  1 Lock Knob (N) – JWBS-20QT only
  2 Lock Knob (N) – JWBS-18QT only

Fence Hardware Bag
  4 5/16-18x3/4 Socket Head Cap Screws (P)
  4 5/16 Flat Washers (Q)
  4 5/16 Lock Washers (R)

Rail Hardware Bag
  9 1/4-20x5/8 Hex Cap Screws (S)
  9 1/4 Flat Washers (T)
  9 1/4 Lock Washers (U)

1 Owner's Manual (not shown)
1 Warranty Card (not shown)

Tools Required for Assembly & Adjustments

The tools listed below are not included but are required for assembly.

2 14mm Open End Wrench
1 Cross Point Screw Driver
1 Combination Square

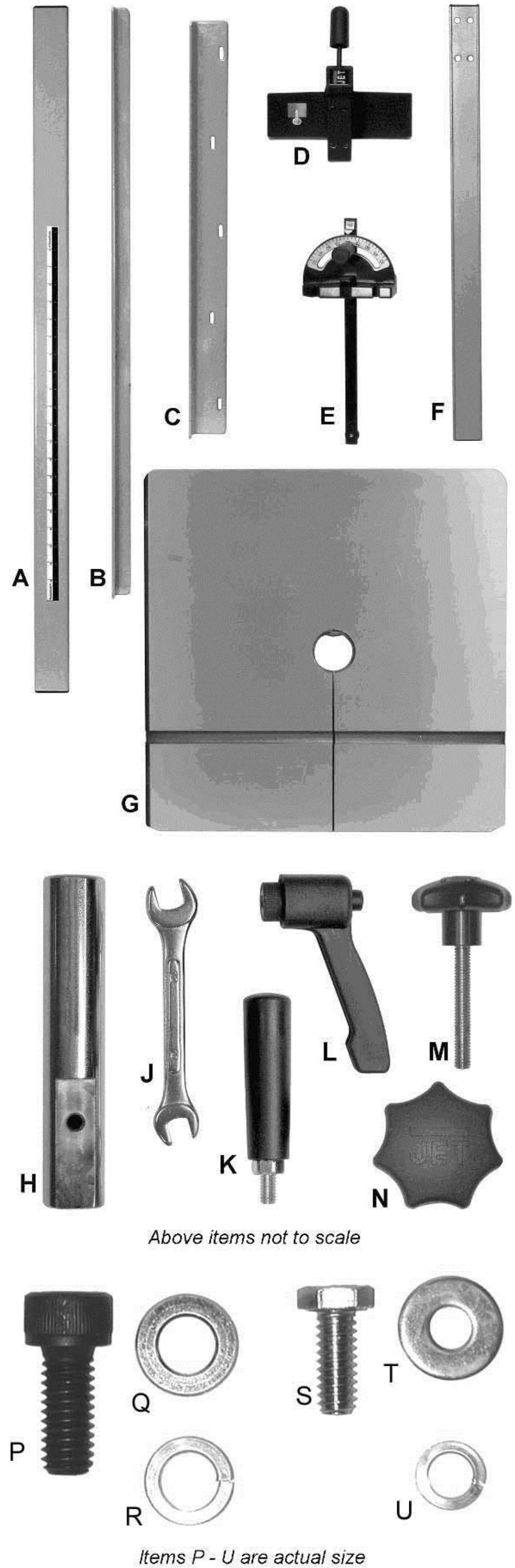


Figure 3 - Hardware

Assembly

Handwheel

Attach the handle (A, Fig. 4) to the handwheel (B, Fig. 4).

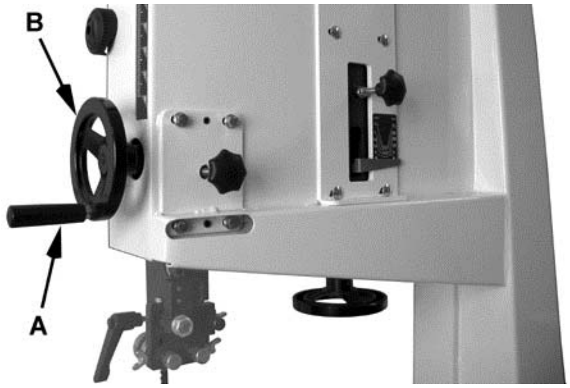


Figure 4

Mounting the Table

Important: The table is heavy. Mounting with the help of another person is recommended.

Referring to Figures 5 and 6:

1. Remove the table *insert* (A) and *tapered pin* (B).
2. Slide the table so the *saw blade* (D) passes through the *slot* where the *tapered pin* (B) was located.
3. Rotate the table 90 degrees so that the miter slot (C) is parallel to the blade (D) and to the right of the blade when facing the band saw as viewed in Figure 6.
4. Line up the *table* (G) to the trunnions so that the *bolts* (F_1, F_2) feed through the *support bracket* (E_1, E_2).

For band saw model JWBS-18QT

Secure the table with two *lock knobs* (H).

For band saw model JWBS-20QT

Secure the table with *lock knob* (H) to bolt F_1 and *lock handle* (J) to bolt F_2.

5. Reinstall the table *insert* (A) and *tapered pin* (B).

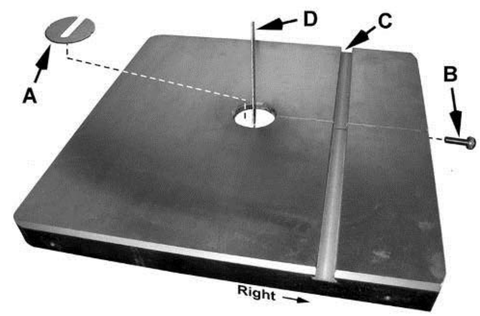


Figure 5

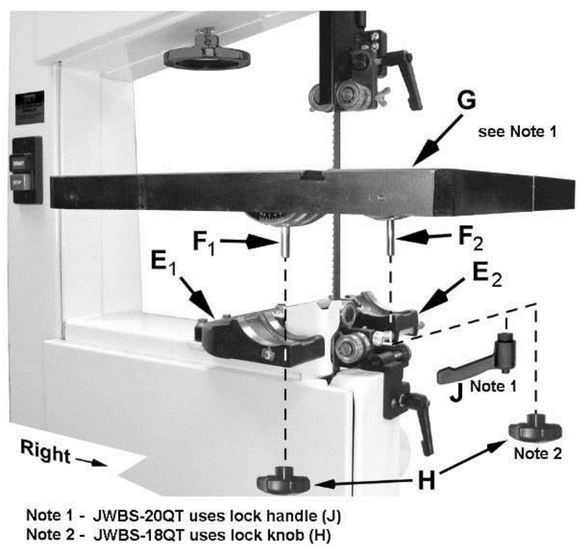


Figure 6

Rail Assembly

Referring to Figure 7:

1. Attach the *front rail* (F) to the cast iron table with two 1/4" x 5/8" *hex cap screws*, two 1/4" *lock washers*, and two 1/4" *flat washers*. The screws should be in approximately the center of the slot. Hand-tighten only at this time.
2. Attach the *rear rail* (G) to the table with two 1/4" x 5/8" *hex cap screws*, two 1/4" *lock washers*, and two 1/4" *flat washers*. Screws should be in approximately the center of the slot. Hand-tighten only at this time.
3. Push the front and rear rails *up* as far as they will go.
4. Using a 10mm wrench, tighten the four hex cap screws holding the front and rear rails to the table. Do not over-tighten the screws.
5. Attach the *guide tube* (H) to the front rail with five 1/4" x 5/8" *hex cap screws*, five 1/4" *lock washers*, and five 1/4" *flat washers*. Screws should be in approximately the center of the slot.

   Hand-tighten the guide tube only at this time. You will be instructed to secure it later in the *Fence Assembly and Adjustment* section.

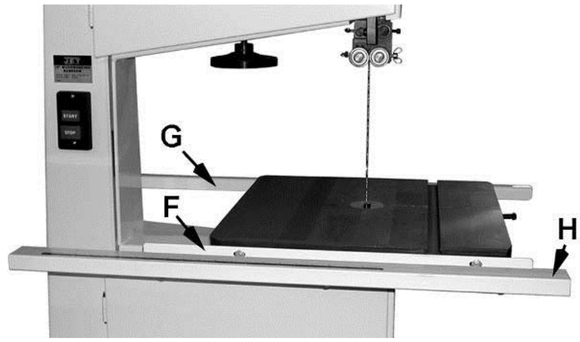


Figure 7

Fence Assembly and Adjustment

Assembling the Fence to Fence Body

Referring to Figure 8:

1. Attach the *fence* (A) to the *fence body* (B) with four 5/16" x 3/4" *socket head cap screws* (C), four 5/16" *lock washers* (D), and four 5/16" *flat washers* (E). Hand-tighten only at this time.

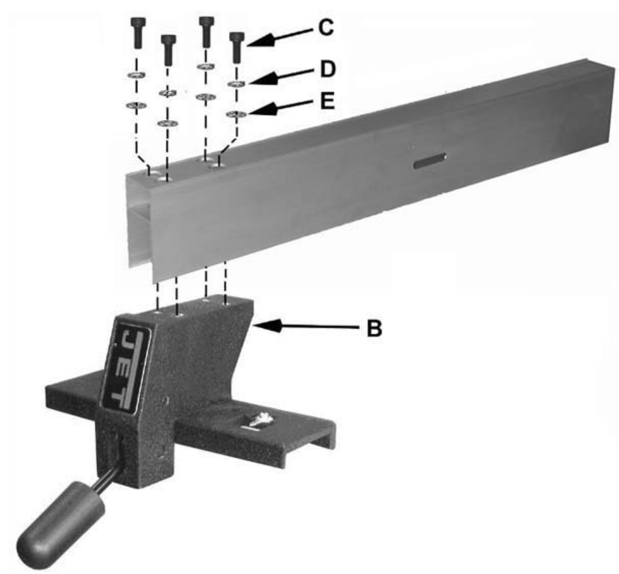


Figure 8

Fence Adjustment

2. Place the fence assembly onto the *guide rail* (D, Fig. 9) and against the edge of the *miter slot* (C, Fig. 9). The hook at the rear of the fence should fit under the rear rail (see Figure 12).

The fence must align parallel to the miter slot along the entire length of the fence.

If adjustment is necessary:

3. Lock the fence by pushing down the *lock handle* (A, Fig. 9). Because the screws are only hand-tight, you can shift the fence slightly as needed until the fence is parallel the miter slot.
4. When the fence has been properly aligned to the miter slot, tighten the four *socket head cap screws* (B, Fig. 9) with a 6mm hex wrench. Make sure the fence remains parallel to the miter slot as you tighten the screws.

   Note: This alignment will again be checked once the guide rail has been tightened.

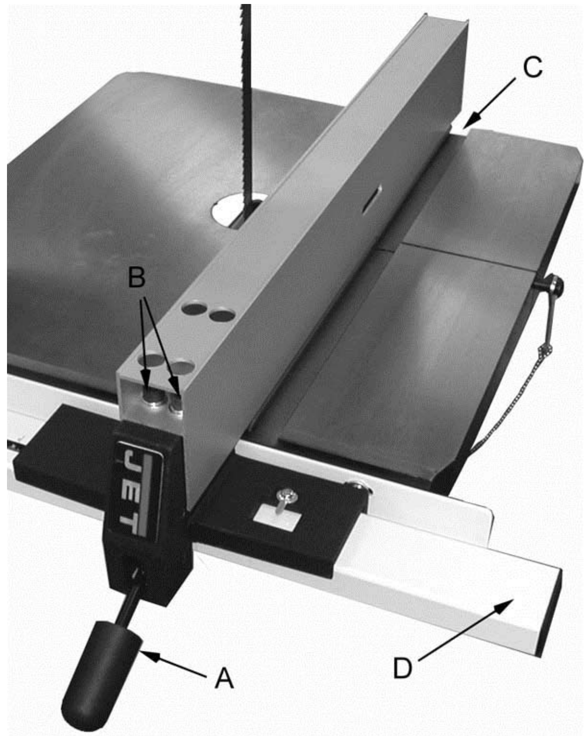


Figure 9

5. Move the fence assembly to the other side of the blade as shown in Figure 10 so that the *pointer* (B, Fig. 10) on the fence body points to *zero* on the scale. Lock the fence by pushing the *handle* (A, Fig. 10) down.
6. Move the guide rail (D, Fig. 10) *with the locked fence* until the fence is flush against the blade (C, Fig. 10). Do not unlock the fence to perform this. Move the fence and guide rail together when establishing the zero point.

   Important: Do not force the fence into the blade so that the blade bends.
7. With a 10mm wrench, tighten the five hex cap screws located on the bottom of the front rail that hold the guide rail to the front rail.

   Note: After tightening the guide rail, double check that the fence is still parallel to the miter slot. Make additional adjustments if needed.

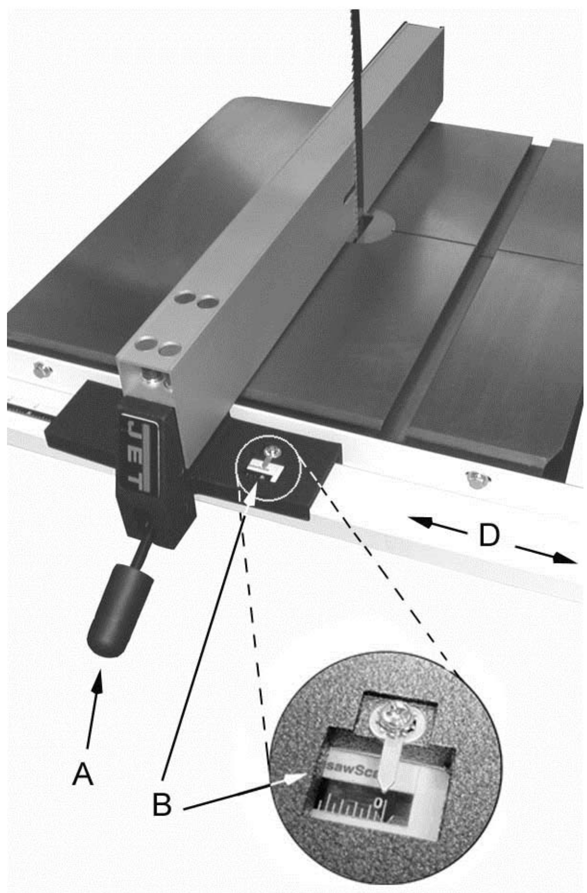


Figure 10

Adjusting Clearance between Fence and Table

Referring to Figures 11 and 12:

Check the clearance between the table and the fence. The fence should not rub against the table surface but be slightly above it. This gap should be the same at the front of the table as it is at the rear.

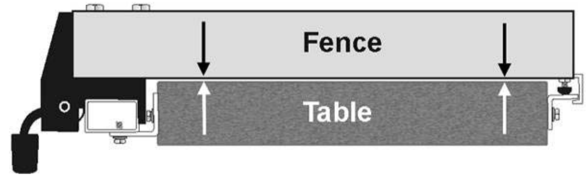


Figure 11

If the gap between fence and table is not consistent, loosen either of the *hex nuts* on the *hook* (Figure 12) and rotate the *sliding pad* until the fence/table gap is consistent across the full length of the table. When this is achieved, tighten both hex nuts.

Check the adjustment of the *hook* at the rear of the fence. The hook should be positioned so that it overlaps the rear rail by approximately 1/8" (Fig. 12). To adjust the hook, loosen the *upper hex nut* and slide the hook in or out as needed. Re-tighten upper hex nut.

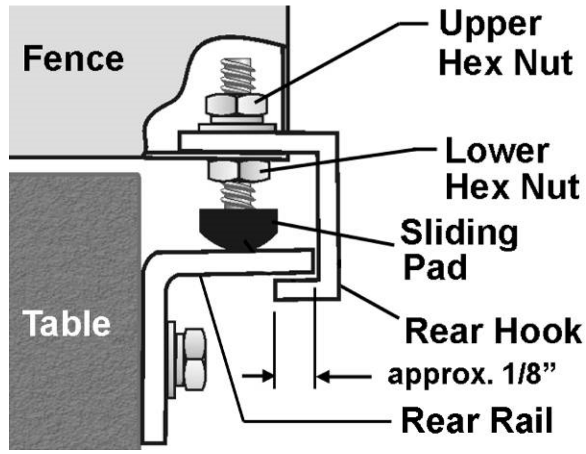


Figure 12

Resaw Guide

For resawing attach the *post* (A, Fig. 13) to the fence with the *lock knob* (B, Fig. 13). There is a slotted hole in the fence that will accommodate the resaw kit. Position the post so that it is centered with the front edge of the blade. The resaw guide will give you a taller, single point contact surface during resawing.

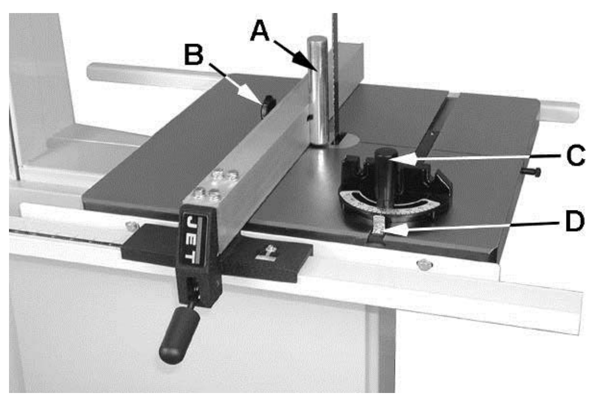


Figure 13

Miter Gauge

1. Place the miter gauge in the table slot.
2. With a square verify the miter gauge face is square to the blade.
3. If the miter gauge is not square to the blade loosen the lock knob (C, Fig. 13) and adjust to the proper setting. Tighten the lock knob.
4. If the pointer is not at 90 degrees, loosen the screw (D, Fig. 13) holding the pointer and move the pointer to 90 degrees.
5. Re-tighten the screw.

Adjustments

Table Tilt

Referring to Figure 14:

1. Disconnect machine from power source.
2. Loosen the *lock knob(s)/lock handle* (G).
3. Tilt table up to 45 degrees to the right, or up to 10 degrees to the left.
4. Tighten the *lock knob(s)/lock handle*.

Note: Table *stop bolt* (F, Fig. 14) must be removed to tilt table to the left.

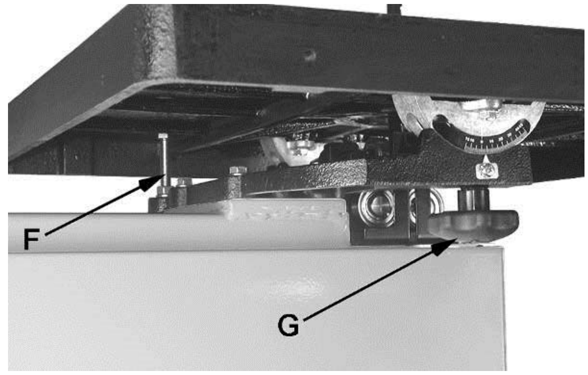


Figure 14

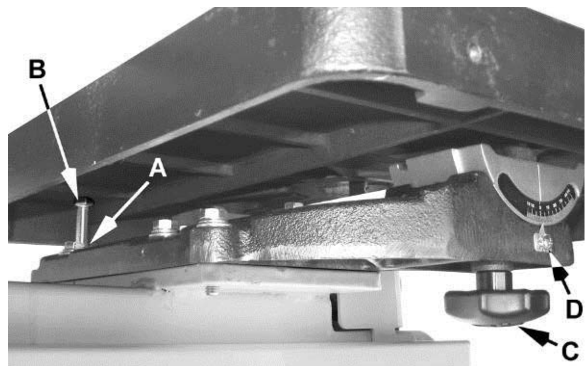


Figure 15

Adjusting 90 Degree Table Stop

Before adjusting the 90º table stop, the blade tension must be properly adjusted (described in the *Blade Tension* section).

To adjust the 90º table stop:

1. Loosen *lock knob(s)/lock handle* (C, Fig. 15) and tilt the table until it rests against table *stop bolt* (B, Fig. 15); then re-tighten the *lock knob(s)/handle*.
2. Use a *square* (E, Fig. 16) placed on the table and against the blade to see if the table is 90 degrees to the blade.
3. If an adjustment is necessary, loosen the *lock knob(s)/handle* (C, Fig. 15). Tilt the table until it is square to the blade; then re-tighten the lock knobs.
4. Loosen *lock nut* (A, Fig. 15) and turn table *stop bolt* (B, Fig. 15) until it contacts the table. Tighten the *nut* (A, Fig. 15) to hold table stop in place. When tightening the nut hold the table stop bolt in place with a wrench to prevent movement.
5. If necessary, adjust the *pointer* (D, Fig. 15) to zero.

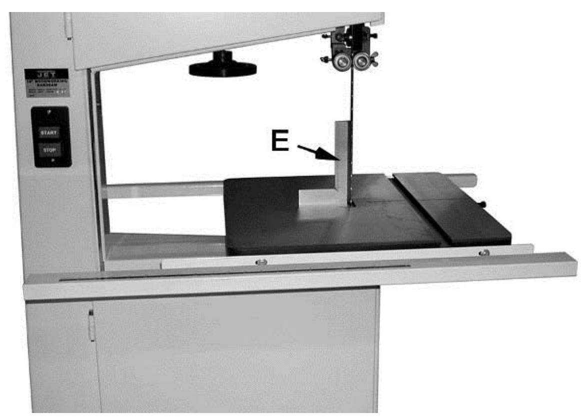


Figure 16

Installing/Changing Blades

⚠WARNING Disconnect machine from power source. Blade teeth are sharp, use care when handling the blade. Failure to comply may cause serious injury.

1. Disconnect machine from power source.
2. Place the *mode selection lever* (J, Fig. 18) in the *Full Release (Blade Change) position*.

   Note 1: When changing the position of the *mode selection lever*, the machine must be turned off.

   Note 2: The *blade tension handwheel* (A, Fig. 17) is primarily used for initial blade tension adjustments (described on following page).
3. Remove the *table insert* (B, Fig. 17).
4. Remove the *tapered pin* (C, Fig. 17) by using the wrench attached together with the pin.
5. Lower the *upper blade guide assembly* (F, fig. 17) by loosening the *knob* (H, Fig. 18) and rotating the *handwheel* (G, Fig. 18) clock-wise.
6. Open *upper* and *lower front doors* (D, Fig. 17).
7. Carefully remove the blade from between upper and lower blade guides and upper and lower wheels; then remove blade through the *table slot* (E, Fig. 17).
8. Guide new blade through *table slot* (E, Fig. 17). Place blade in upper and lower blade guides.

   Note: Make sure blade teeth point down toward table (see inset, Fig. 17), and toward the front of the saw.

   Hint: If the teeth cannot be made to point down, try turning the blade inside out first, then reattempt.
9. Position blade on the middle of the upper and lower wheels.
10. Replace the *table insert* (B, Fig. 17) and *tapered pin* (C, Fig. 17).
11. Place the lever (J, Fig. 18) to the *Full Tension* or *Partial Tension (Idle/Tracking)* position.

Before operating the band saw, the new blade must be adjusted and blade guides re-adjusted. The required adjustments are contained in the sections listed below and which follow immediately:

- ❐ Blade Tension (page 16)
- ❐ Blade Tracking (page 16)
- ❐ Upper Bearing Adjustment (page 17)
- ❐ Lower Bearing Adjustment (page 18)

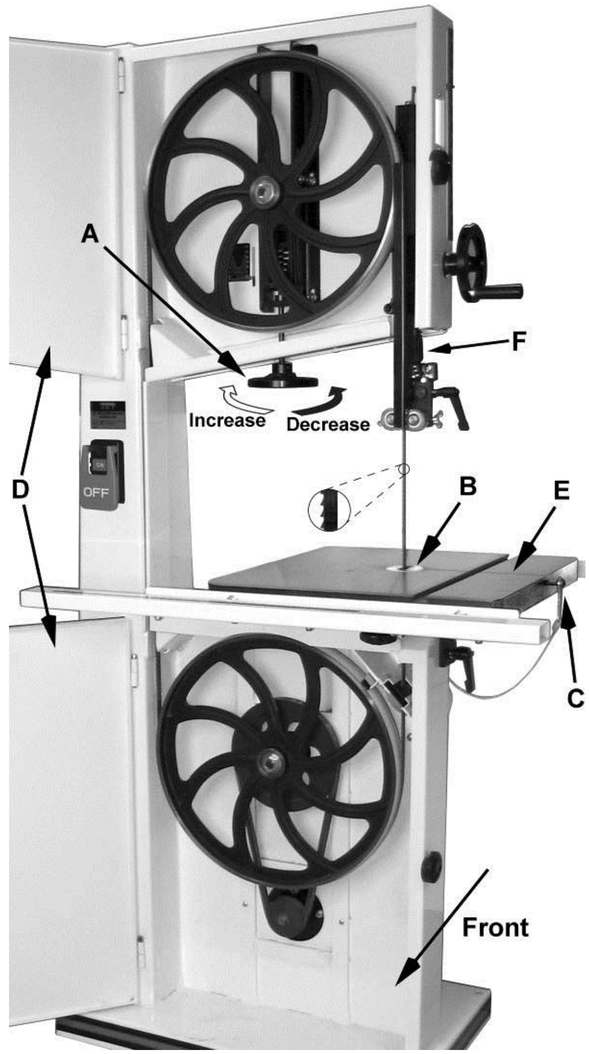


Figure 17

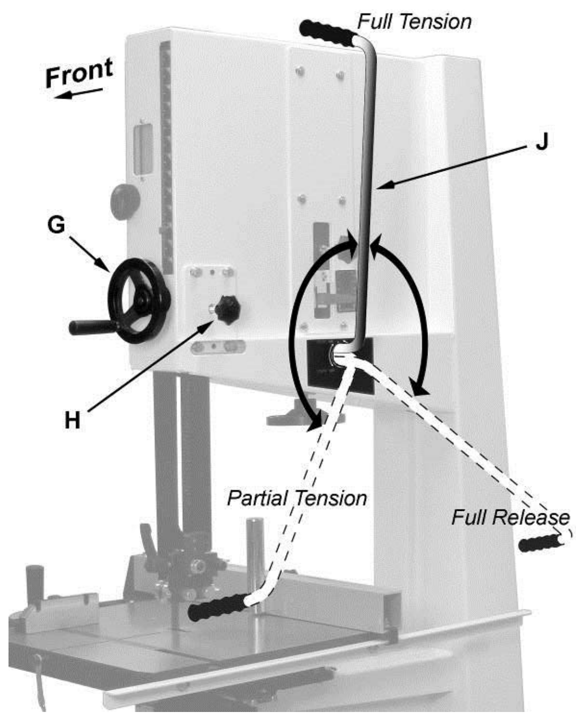


Figure 18

Blade Tension

Blade tension is set with the *blade tension handwheel* (A, Fig. 19) and is performed following blade replacement and periodically as the blade stretches from use.

⚠WARNING Disconnect machine from power source before making any adjustments.

Referring to Figure 19:

1. Place the *mode selection lever* (F) in the *Full Tension* position (see Figure 18).
2. Set the blade tension by rotating the *handwheel* (A) according to the *arrow directions* shown in Figure 19.

   The *gauge* (B) indicates the approximate tension according to the width of the blade in inches. Initially, set the blade tension to correspond to the width of your blade.

   The JWBS-18QT comes with a 3/4" blade so the tension should be set at 3/4" when using this blade.

   The JWBS-20QT comes with a 1" blade so the tension should be set at 1" when using this blade.

   Note: For the JWBS-18QT the tension gauge can also be seen from the front of the saw through the wheel when the upper door is open.

As you become familiar with the saw, you may find it necessary to change the blade tension from the initial setting.

Keep in mind that too little or too much blade tension can cause blade breakage and/or poor cutting performance.

Tip: When the band saw is not being used, place the *mode selection lever* (J, Fig. 18) to the *Partial Tension* position – this will prolong the blade's life.

Blade Tracking

Tracking refers to the position of the saw blade on the wheels while the machine is in operation. Tracking has been factory-adjusted. However, it should be checked occasionally, including after every blade change.

⚠WARNING Disconnect machine from power source before making any adjustments.

Important: The blade must be in Full or Partial Tension positions *before* adjusting blade tracking (see previous section). Make sure the blade guides and other parts of the machine will not interfere with the movement of the blade.

To inspect and adjust tracking, proceed as follows:

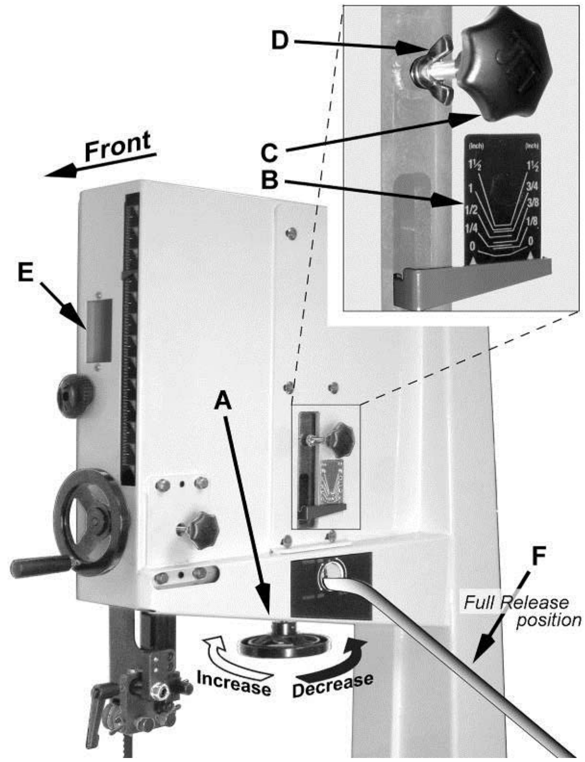


Figure 19

1. Open upper front door to expose the wheel. Rotate the wheel clockwise by hand and observe the position of the blade on the wheel through the window (E, Fig. 19). The blade should ride upon the center of the wheel as shown in Figure 20.
2. If the blade tends to move toward the edge of the wheel, loosen the *wing nut* (D, Fig. 19) and slightly rotate the *knob* (C, Fig. 19). Rotating the knob clockwise will cause the blade to move toward the rear edge of the wheel. Rotating the knob counterclockwise will cause the blade to move toward the front edge of the wheel.

   Note: This adjustment is sensitive; perform it in small increments and give the blade time to react to the changes as you continue to rotate the wheel.
3. When the blade is tracking properly in the center of the wheel, re-tighten the *wing nut* (D, Fig. 19).
4. Close the upper front door.

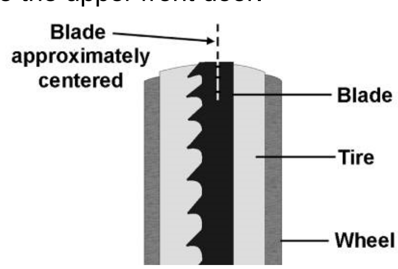


Figure 20

Overview – Bearing Adjustments

Thrust (back support) *bearing* are located behind the saw blade and provide support to the back of the blade when the saw is in operation.

Guide bearings are located on either side of the saw blade and provide stability for the blade when the saw is in operation. These bearings rotate on an eccentric shaft so the distance from the blade can be adjusted for optimal performance.

Upper Bearing Adjustments

⚠WARNING Unplug the machine from power source before making any adjustments! Blade teeth are sharp - use care when working near the saw blade. Failure to comply may cause serious injury.

Note: Blade tension and tracking must be properly adjusted prior to bearing guide setup. Refer to the *Blade Tension* section (previous page).

To adjust the thrust bearing:

1. Place the *mode selection lever* (J, Fig. 18) in the *Full Tension* position.

Referring to Figure 21:

2. Loosen the *wing nut* (E) and slide the bearing and bearing post until the space between the *thrust bearing* (H) and the back edge of the *blade* (G) is approximately 1/64”.

   A convenient way to achieve this spacing is by placing a dollar bill folded twice (four thicknesses) between the blade and support bearing – four thicknesses of a dollar bill is approximately 1/64”.

3. Tighten *wing nut* (E).

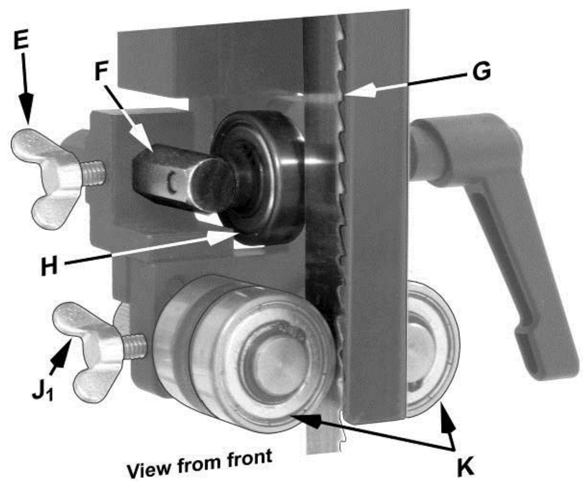


Figure 21

To adjust the guide bearings (refer to Figure 22):

4. Loosen the *locking handle* (L) and slide the assembly until the front of the *guide bearings* rest just behind the *gullet* of the blade teeth (see inset).

5. Loosen two *wing nuts* (J_1, J_2). Rotate the *adjustment handles* (M) until the *guide bearings* (K) rest lightly against the *blade* (N). *Do not force* the guide bearings against the side of the blade.

6. Tighten *wing nuts* (J_1, J_2 Fig. 22).

Check to make sure the adjustments have not changed and the bearing guides do not pinch the blade.

Place the *mode selection lever* (J, Fig. 18) in the *Partial Tension* position when the machine is not in use.

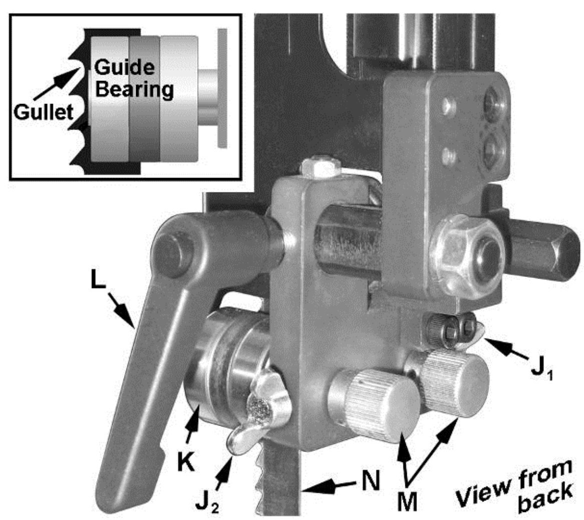


Figure 22

Lower Bearing Adjustments

⚠WARNING Unplug the machine from power source before making any adjustments! Blade teeth are sharp - use care when working near the saw blade. Failure to comply may cause serious injury.

Note: Blade tension and tracking must be properly adjusted prior to bearing guide setup. Refer to the *Blade Tension* section (page 16).

1. Place the *mode selection lever* (J, Fig. 18) in the *Full Tension* position.

Referring to Figure 23:

2. Loosen the *thumb screw* (B).

   This will allow the *thrust bearing* (A) to move freely and prevent interference with the *saw blade* (C) during the following steps.

Guide Gearings Adjustment

3. Loosen the *locking handle* (D) then turn the *adjustment screw* (E) to adjust the assembly forward or backward until the front of the *guide bearings* (F) rest just behind the *gullet* of the blade teeth (C and *inset*).
4. Tighten the *locking handle* (D).

Thrust Bearing Adjustment

5. With the *thumb screw* still loose (from Step 1), slide the *thrust bearing* and *bearing post* until the space between the *bearing* (A) and the back edge of the *blade* (C) is approximately 1/64".

   A convenient way to achieve this spacing is by placing a dollar bill folded twice (four thicknesses) between the blade and support bearing – four thicknesses of a dollar bill is approximately 1/64".

6. Tighten the *thumb screw* (B).
7. Loosen the *lock knob* (G). Rotate the *adjustment handles* (H) until the *guide bearings* (F) rest lightly against the *blade* (C). *Do not force* the guide bearings against the side of the blade.
8. Tighten the *lock knob* (G).

Check to make sure the adjustments have not changed and the bearing guides do not pinch the blade.

Place the *mode selection lever* (J, Fig. 18) in the *Partial Tension* position when the machine is not in use.

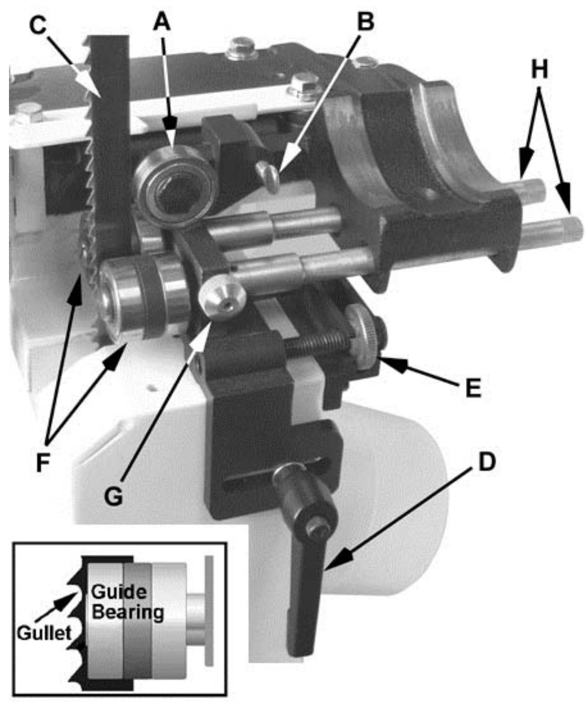


Figure 23

Blade Lead

Blade drift (also known as *lead* or *fence drift*) is a problem that may occur when the blade begins to wander off the cutting line even when the band saw fence is being used. Figure 24 shows an example of blade lead.

Blade lead can be caused by a number of factors, and these should all be checked and corrected if necessary:

- ❒ Fence is not parallel to miter slot and blade.
- ❒ Blade is not tensioned correctly.
- ❒ Blade is dull.
- ❒ Teeth have too much "set" on one side of the blade.

If replacement of the blade is not currently an option, the blade lead can be compensated for by skewing the fence. Proceed as follows:

1. Cut a scrap piece of wood about the same length as the band saw table, and joint one edge along its length, or rip it on a table saw to give it a straight edge.
2. Draw a line on the board parallel with the jointed, or straight edge of the board.
3. Move the band saw fence out of the way, and carefully make a freehand cut along your drawn line on the board. Stop about midway on the board, and shut off the band saw (allow the blade to come to a complete stop) but do not allow the board to move.
4. Clamp the board to the table.
5. Slide the band saw fence over against the board until it contacts the straight edge of the board at some point. Lock the fence down.
6. Loosen the four hex cap screws at the top of the fence (see Figure 9) and shift the fence until it is parallel to the board along its length.
7. Re-tighten the four hex cap screws.

Note: Skewing the fence to correct blade lead is effective for that particular blade; when a new blade is installed, the fence will probably need re-adjustment.

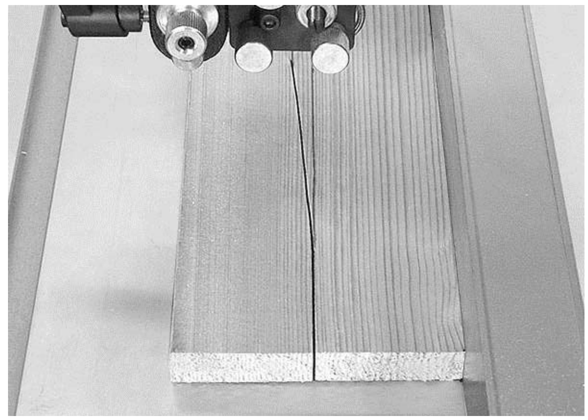


Figure 24

Changing the Blade Speed

⚠WARNING Disconnect machine from power source before making any adjustments.

The JWBS-18QT and -20QT band saw has two blade-speed options which is determined by the position of the pulley drive belt. Refer to the *Specifications* section (page 6) for speed specs.

To change the blade speed (while referring to Figure 25):

1. Loosen the *lock handle* (A) that secures the *motor* (C).
2. Release belt tension by pulling *handle* (B) up which raises the motor, then tighten *lock handle* (A).
3. Open the lower wheel *door* (C, Fig. 27).
4. Referring to Figure 26:

   For *higher blade-speed* – place the poly V-belt in the A position on the spindle and motor pulleys as shown in Figure 26.

   For *lower blade-speed* – place the poly V-belt in the B position on the spindle and motor pulleys.

After repositioning the belt:

5. Unlock *lock handle* (A, Fig. 25). Apply belt tension by slightly pushing *handle* (B, Fig. 25) down.
6. Tighten the *lock handle* (A, Fig, 25) to secure the *motor* (C, Fig. 25).

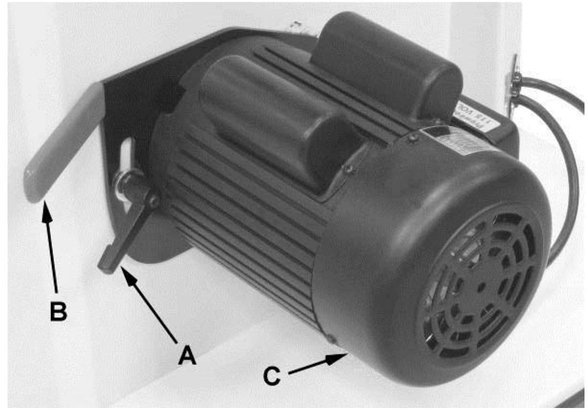


Figure 25

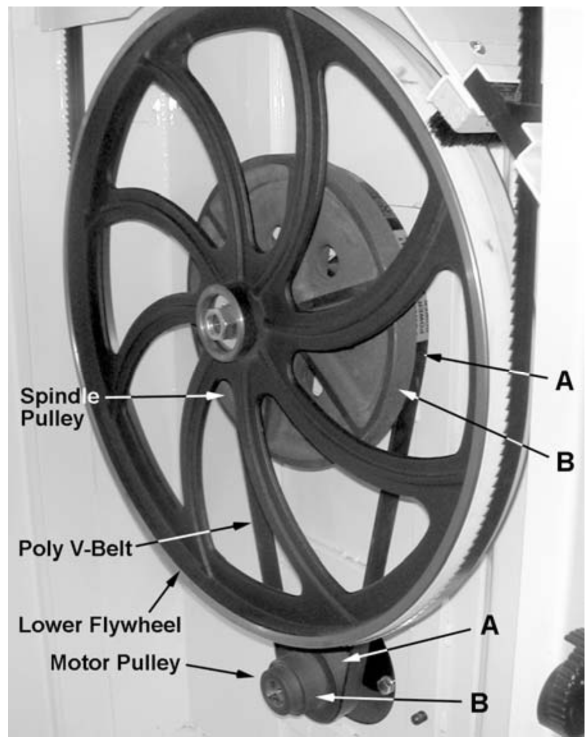


Figure 26

Belt Tension

The drive belt and pulleys are properly adjusted at the factory. However, belt tension should be occasionally checked. The belt will need to be re-tensioned after belt replacement.

⚠WARNING Disconnect machine from power source before making any adjustments.

Referring to Figure 25:

1. Loosen the *lock handle* (A) that secures the *motor* (C).
2. Set the belt tension by lightly pressing down on the *handle* (B).

   The weight of the motor should put enough tension on the belt. You just want to push down lightly to take up any slack.
3. Tighten the *lock handle* (A).

Note: A new belt may stretch slightly during the "breaking in" process, and the tension may occasionally need to be checked and adjusted.

Place the *mode selection lever* (J, Fig. 18) in the *Partial Tension* position when the machine is not in use.

Replacing the Poly V-Belt

⚠WARNING Disconnect machine from power source before making any adjustments.

1. Place the *mode selection lever* (J, Fig. 18) in the *Full Release* position.

Referring to Figure 25:

2. Loosen the *lock handle* (A) that secures the *motor* (C).
3. Release belt tension by pulling *handle* (B) up which raises the motor, then tighten *lock handle* (A).
4. Open the lower wheel *door* (C, Fig. 27) and remove the *hex nut* and *washer* (D, Fig. 27).
5. Remove the *wheel* (E, Fig. 28). If the lower wheel does not come off easily you may need to use a pulley puller to remove it.

Note: If you are doing a pulley alignment *only*, skip Step 6.

6. Remove the *old belt* (F, Fig. 28) and install the new belt.

   Note: For *higher blade-speed*, place the belt on the pulleys closest to the motor (A, Fig. 26). For *lower blade-speed*, place the belt on the pulleys away from the motor (B, Fig. 26).

Since the wheel is still off, this is the most convenient time to check the wheel and motor pulley alignment. Jump to the *Pulley Alignment* procedure (following page) at this time. At the conclusion you will be redirected back here.

After the pulley alignment (if performed) is complete:

7. Reinstall the lower wheel, hex nut and washer and tighten the hex nut.
8. Unlock *lock handle* (A, Fig. 25). Apply belt tension by slightly pushing *handle* (B, Fig. 25) down.
9. Tighten the *lock handle* (A, Fig, 25) to secure the *motor* (C).

Important: Before operating the band saw, refer to the sections listed below and perform the required adjustments described in them.

- ❒ Installing/Changing Blades (page 15)
- ❒ Belt Tension (below)
- ❒ Blade Tension (page 20)
- ❒ Blade Tracking (page 16)
- ❒ Upper Bearing Adjustments (page 17)
- ❒ Lower Bearing Adjustments (page 18)

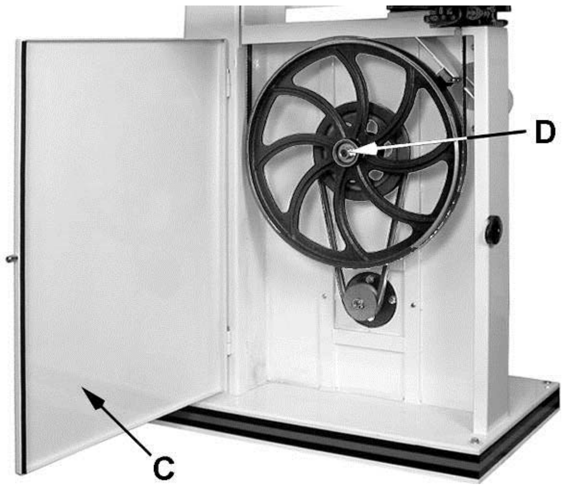


Figure 27

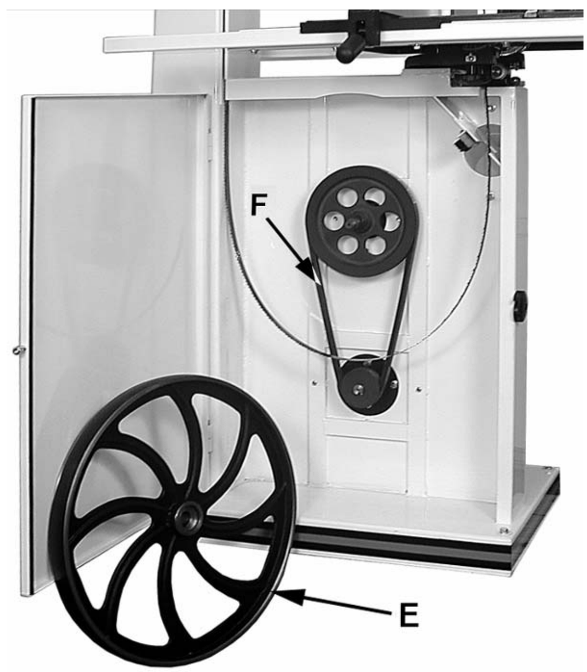


Figure 28

Pulley Alignment

The pulley alignment is done in conjunction with the poly V-belt replacement.

If you are just beginning the alignment, start with the *Replacing the Poly V-Belt* section (previous page.

If you were directed here, proceed as follows:

1. Uses a straight edge placed against the wheel pulley and motor pulley and refer to Figure 29 to determine if alignment is necessary.

If alignment is necessary:

2. With a 4mm hex wrench, loosen two set screws on the motor (lower) pulley.
3. Adjust the motor pulley by sliding in or out.
4. Confirm the alignment of the poly V-belt by placing a straight edge against the faces of both pulleys, (Figure 29). If the straight edge lies flush against both pulleys, then the pulleys and belt are aligned.
5. Re-tighten the two set screws on the motor pulley.

Return to *Step 7* of the *Replacing Poly V-Belt* section on page 21.

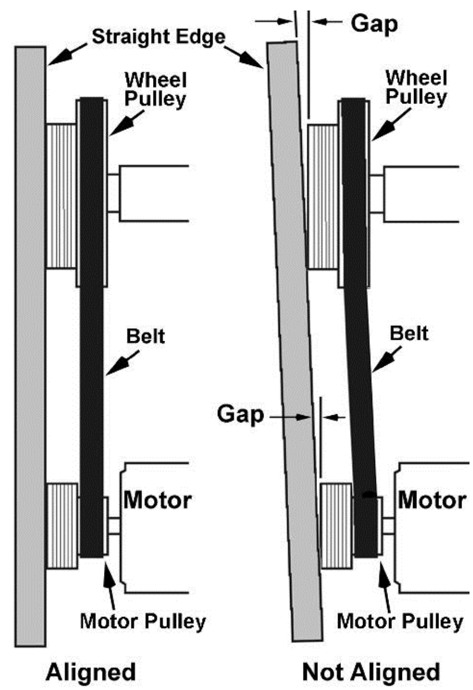


Figure 29

Operating Controls

Start/Stop Switch

The switch shown in Figure 30 is used on model JBWS-18QT band saw.

Press the green *on* button (A, Fig. 4) to start. Press the red safety switch *off* button (B, Fig. 4) to stop.

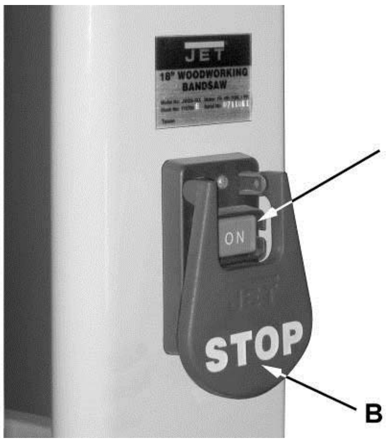


Figure 30 – Start/Stop Switch

The switch shown in Figure 31 is a magnetic switch used on the JBWS-18QT-3 and all JBWS-20QT model band saws.

Power Indicator Light – The *start switch* has a power indicator lamp which is *on* ***whenever there is power connected*** to the band saw, not just when the band saw is running. *Do not assume that no light means there is no power to the machine.* If the bulb is bad, there will no indication. Always check before use.

⚠WARNING Do not rely that no light means no power to the machine. Always check for power first. Failure to comply may cause serious injury!

To operate the magnetic Start/Stop switch (referring also to Figure 31):

Start – Press the green start switch.

When power is connected to the machine, the green light is always on regardless of whether the band saw is running or not.

Stop – Press the red switch to stop.

Reset – In the event that the band saw stops without pressing the stop button, as the result of a tripped fuse or circuit breaker, etc.:

1. Press red button to reset
2. Press the green button to restart the machine.

Safety Key **–** The magnetic Start/Stop switch comes equipped with a magnetic *safety key*. When in position *on the switch* as shown in Figure 31, the magnetic *safety key* trips a relay which will allow the machine to start and stop when the respective switches are pressed. Being magnetic, the *safety key* can be removed to make the machine inoperable and can be hidden for safe storage by attaching it underneath the rail or another magnetic surface.

When using a saw equipped with this switch, place the *safety key* on the switch cover, lining up the arrow on the key with the REMOVE arrow on the cover. Then rotate the key so the arrow lines up with the LOCK arrow. This will prevent the safety key from coming loose from vibration when the machine is in use.

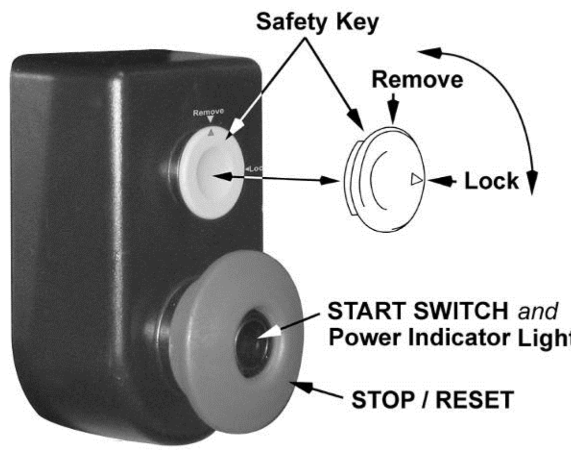


Figure 31 – Magnetic Start/Stop Switch

Brake Pedal (JWBS-20QT only)

Press the brake pedal (A, Fig. 32) while the saw is running to stop the saw. Re-start the saw by pressing the on switch.

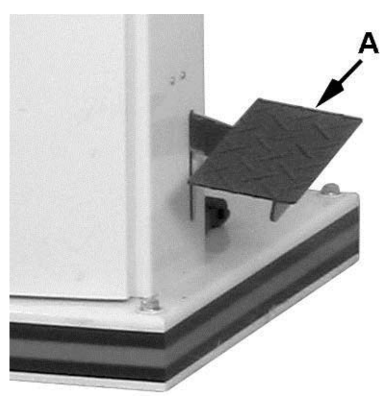


Figure 32 – Brake Pedal

Operation

Note: The following Figures may or may not show your particular band saw model, but the procedures are identical.

General Procedure

1. Make sure the blade and upper and lower bearings are properly adjusted for tension and tracking.
2. Adjust blade guide assembly so that the guide bearings are just above the workpiece (about 3/16") allowing minimum exposure to the blade. See Figure 33.
3. If using the fence, move it into position and lock it to the guide rail. If you are using the miter gauge for a crosscut, the fence should be moved safely out of the way.
4. Turn on the band saw and allow a few seconds for the machine to reach full speed.

⚠WARNING Whenever possible, use a push stick, hold-down, power feeder, jig, or similar device while feeding stock, to prevent your hands getting too close to the blade.

5. Place the straightest edge of the workpiece against the fence, and push the workpiece slowly into the blade. Do not force the workpiece into the blade.

⚠CAUTION When cutting, do not overfeed the blade; overfeeding will reduce blade life and may cause the blade to break.

6. When cutting long stock, the operator should use roller stands, support tables, or an assistant to help stabilize the workpiece.

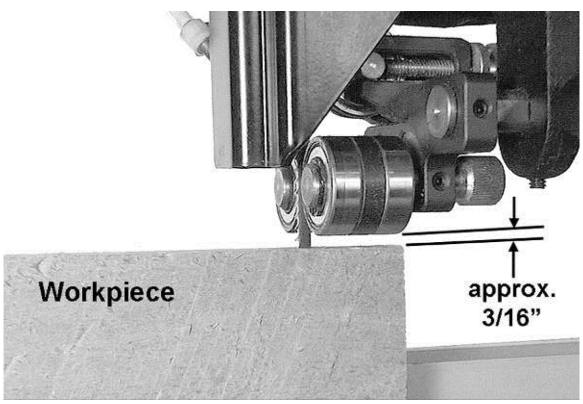


Figure 33

Ripping

Ripping is cutting lengthwise down the workpiece, and with the grain (of wood stock). See Figure 34.

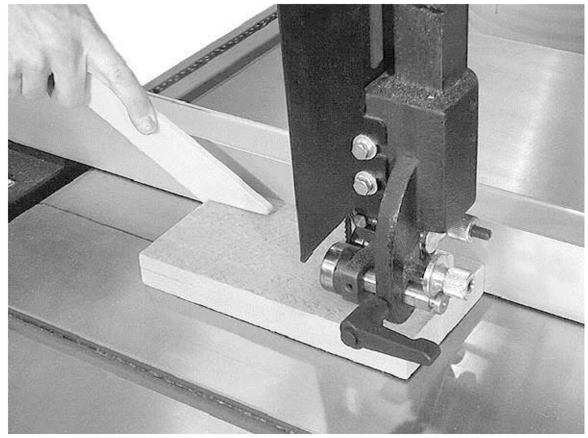


Figure 34

Crosscutting

Crosscutting is cutting across the grain of the workpiece, while using the miter gauge to feed the workpiece into the blade.

Slide the bar of the miter gauge into the end of the slot on the table.

The right hand should hold the workpiece steady against the miter gauge, while the left hand pushes the miter gauge past the blade, as shown in Figure 35.

Do not use the fence in conjunction with the miter gauge. The offcut of the workpiece must not be constrained during or after the cutting process.

⚠CAUTION Using the fence in conjunction with the miter gauge can cause binding and possible damage to the blade.

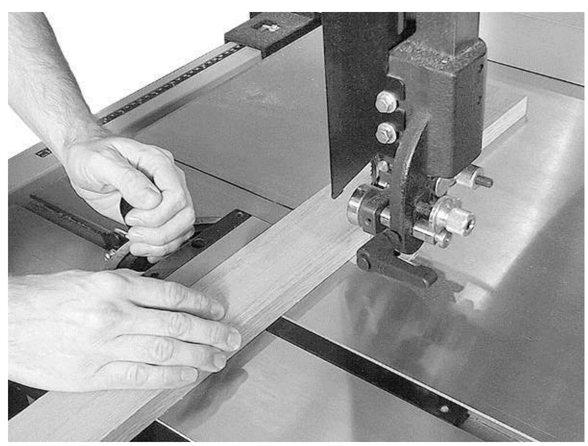


Figure 35

Resawing

Resawing is the process of slicing stock to reduce its thickness, or to produce boards that are thinner than the original workpiece. Figure 36 demonstrates resawing.

The ideal blade for resawing is the widest one the machine can handle, as the wider the blade the better it can hold a straight line.

When resawing thin stock, use a push block, push stick, or similar device to keep your hands away from the blade.

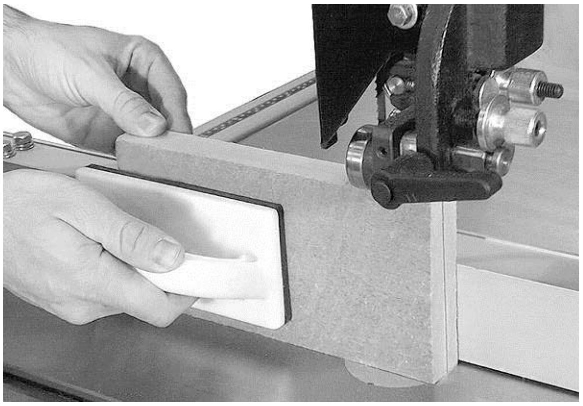


Figure 36

Saw Blade Selection

Using the proper blade for the job will increase the operating efficiency of your band saw, help reduce necessary saw maintenance, and improve your productivity. Thus, it is important to follow certain guidelines when selecting a saw blade.

Here are factors to consider when selecting a blade:

- ❒ The type of material you will be cutting.
- ❒ The thickness of the workpiece or part.
- ❒ The features of the workpiece or part, such as bends or curves with small radii.

These factors are important because they involve basic concepts of saw blade design. There are five (5) blade features that are normally changed to meet certain kinds of sawing requirements. They are:

1. width
2. pitch (number of teeth per inch),
3. tooth form (or shape),
4. the "set" of the teeth
5. the blade material itself.

Width

Band saw blades come in different standard widths, measured from the back of the blade to the tip of the tooth. Generally, wider blades are used for ripping or making straight cuts; narrower blades are often used when the part being cut has curves with small radii. When cutting straight lines with a narrow blade, the blade may have a tendency to wander, causing *blade lead*. (refer to the *Blade Lead* section in *Adjustments*).

Pitch

Pitch is measured in "teeth per inch" (TPI). Figure 37 shows blades with different pitches. A fine pitch (more teeth per inch) will cut slower but smoother. A coarse pitch (fewer teeth per inch) will cut rougher but faster. As a rule of thumb, the thicker the workpiece, the coarser will be the blade pitch. If you have to cut a hard or very brittle material, you will probably want to use a blade with a finer pitch in order to get good clean cuts.

General rule: Use a blade that will have no fewer than 6 and no more than 12 teeth in the workpiece at any given time.

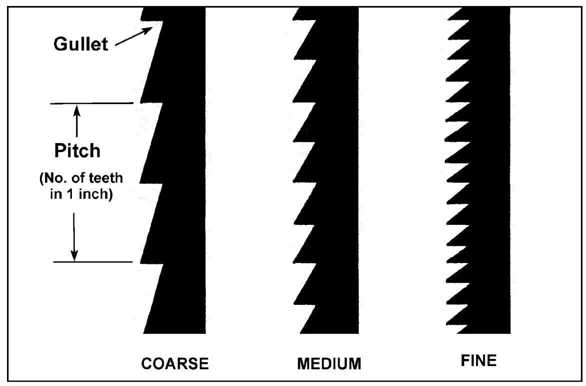


Figure 37

Shape

Figure 38 shows common types of tooth shape. Tooth shape has an effect on cutting rate, and with few exceptions, the Skip and Hook types are used to obtain higher feed rates when cutting thick workpieces. Variable-tooth blades are also available, which combine features of the other styles.

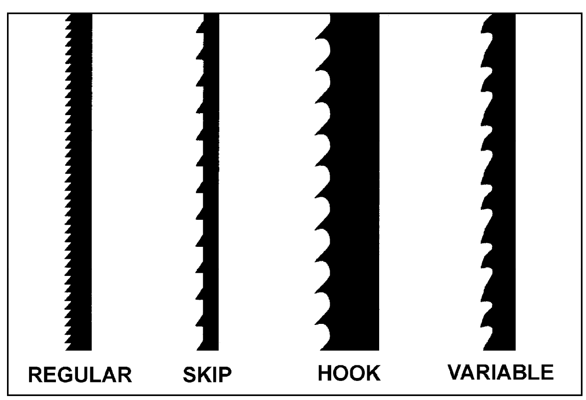


Figure 38

Set

The term "set" refers to the way in which the saw teeth are bent or positioned. Set patterns are usually selected depending on the type of material that needs to be cut. Three common set patterns are shown in Figure 39.

Generally, the *Raker* set is used for cutting metal workpieces; the *Wave* set, when the thickness of the workpiece changes, such as cutting hollow tubing or structurals. The *Straight* set is most often preferred when cutting wood or plastics.

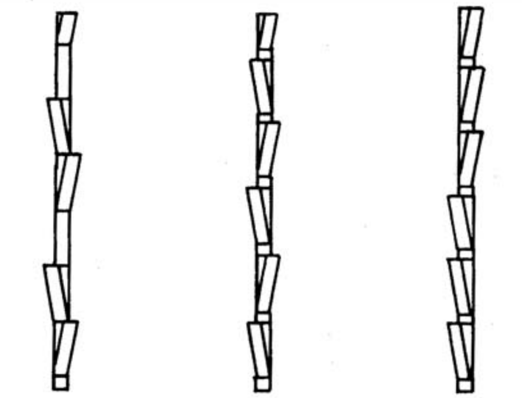


Figure 39

Material

Band saw blades can be made from different types of materials. Some of the most common include spring steel, carbon steel, carbon steel equipped with a high speed or welded edge (bi-metal), or carbide tips. A special type of saw blade is made from "high speed steel"; these should not be used on band saws with low rates of speed.

Because of the importance of blade selection, it is recommended that you use the *Blade Selection Guide* on page 27.

⚠WARNING When cutting, do not overfeed the blade; overfeeding will reduce blade life, and may cause the blade to break.

Blade Breakage

Band saw blades are subject to high stresses and breakage may sometimes be unavoidable. However, many factors can be controlled to help prevent most blade breakage. Here are some common causes for breakage:

1. Misalignment of the blade guides
2. Feeding work too fast
3. Using a wide blade to cut a short radius curve
4. Excessive tension
5. Teeth are dull or improperly set
6. Upper guides are set too high off the workpiece
7. Faulty weld on blade

Maintenance

⚠WARNING Before any intervention on the machine, disconnect it from the electrical supply by pulling out the plug. Failure to comply may cause serious injury.

Keep bearing guides clean and free of build-up.

Check that the cleaning brush over the band wheel is working properly, and remove any deposits from the band wheels to avoid vibration and blade breakage.

The table surface should be kept clean and free of rust for best results. Some users prefer a paste wax coating. Another option is talcum powder applied with a blackboard eraser rubbed in vigorously once a week; this will fill casting pores and form a moisture barrier. This method provides a table top that is slick and allows rust rings to be easily wiped from the surface. Important also is the fact that talcum powder will not stain wood or mar finishes as wax pickup does.

Do not let saw dust build up in the upper and lower wheel housings. Vacuum out frequently.

Connect the band saw to a JET dust collection system.

Clean and grease the raising/lowering rack for the upper bearing guides if it becomes difficult to raise or lower.

Clean and oil the tensioning mechanism if it becomes difficult to adjust.

Vacuum out the motor fan cover.

Blade Selection Guide

Identify the material and thickness of your workpiece. The chart will show the recommended PITCH, blade TYPE, and FEED RATE.

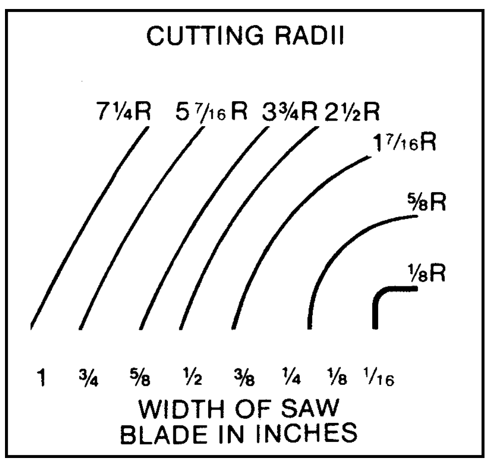
Key: H – Hook L – Low
S – Skip M – Medium
R – Regular H – High

Example: 10/H/M means 10 teeth per inch / Hook Type Blade / Medium Feed

Material/s		Workpiece Thickness			
		1/2"	1"	3"	6+"
Woods	Hardwood	10/R/L	8/R/L	3/H/M	3/H/M
	Softwood	10/R/L	8/R/L	3/H/M	3/H/M
Non-Metals	Carbon	10/R/L	6/R/L	3/S/M	3/S/M
	Mica	32/R/L	--	--	--
	Asbestos	8/R/L	6/R/L	3/S/M	3/S/M
	Hard Rubber	10/R/L	8/R/L	6/R/M	2/S/H
Plastics	Formica	14/R/M	10/R/M	4/H/H	4/H/H
	Masonite	10/R/L	4/S/L	3/S/M	3/H/M
	Micarta	14/R/M	10/R/M	4/H/H	3/H/H
	Plexiglas	10/R/L	6/R/L	3/S/M	3/S/M
	Paper	14/R/L	10/R/L	4/S/L	3/S/M

Study the part drawing or prototype, or actually measure the smallest cutting radius required, and locate this radius (in inches) on the chart at the right. Follow the curve to where the approximate blade width is specified. If a radius falls between two of the curves, select the widest blade that will saw this radius.

This procedure should be used for making initial blade selections. These recommendations can, of course, be adjusted to meet specific requirements of a cutting job. Compromises may be necessary if you cannot find all needed specifications in a single blade.



Troubleshooting

Trouble	Probable Cause	Remedy
Saw stops or will not start	Saw unplugged	Check plug connections
	Fuse blown, or circuit breaker tripped	Replace fuse, or reset circuit breaker
	Cord damaged	Replace cord
Does not make accurate 45° or 90° cuts	Stop not adjusted correctly	Check blade with square and adjust stop
	Angle pointer not set accurately	Check blade with square and adjust pointer
	Miter gauge out of adjustment	Adjust miter gauge
Blade wanders during cut	Fence not aligned with blade	Check and adjust fence
	Warped wood	Select another piece of wood
	Excessive feed rate	Reduce feed rate
	Incorrect blade for cut	Change blade to correct type
	Blade tension not set properly	Set blade tension according to blade size
	Guide bearings not set properly	Review guide bearing adjustment.
Saw makes unsatisfactory cuts	Dull blade	Replace blade
	Blade mounted wrong	Teeth should point down
	Gum or pitch on blade	Remove blade and clean
	Incorrect blade for cut	Change blade to correct type
	Gum or pitch on table	Clean table
Blade does not come up to speed	Extension cord too light or too long	Replace with adequate size and length cord
	Low shop voltage	Contact your local electric company
Saw vibrates excessively	Base on uneven floor	Reposition on flat, level surface
	Bad v-belt	Replace v-belt
	Motor mount is loose	Tighten motor mount hardware
	Loose hardware	Tighten hardware

Parts

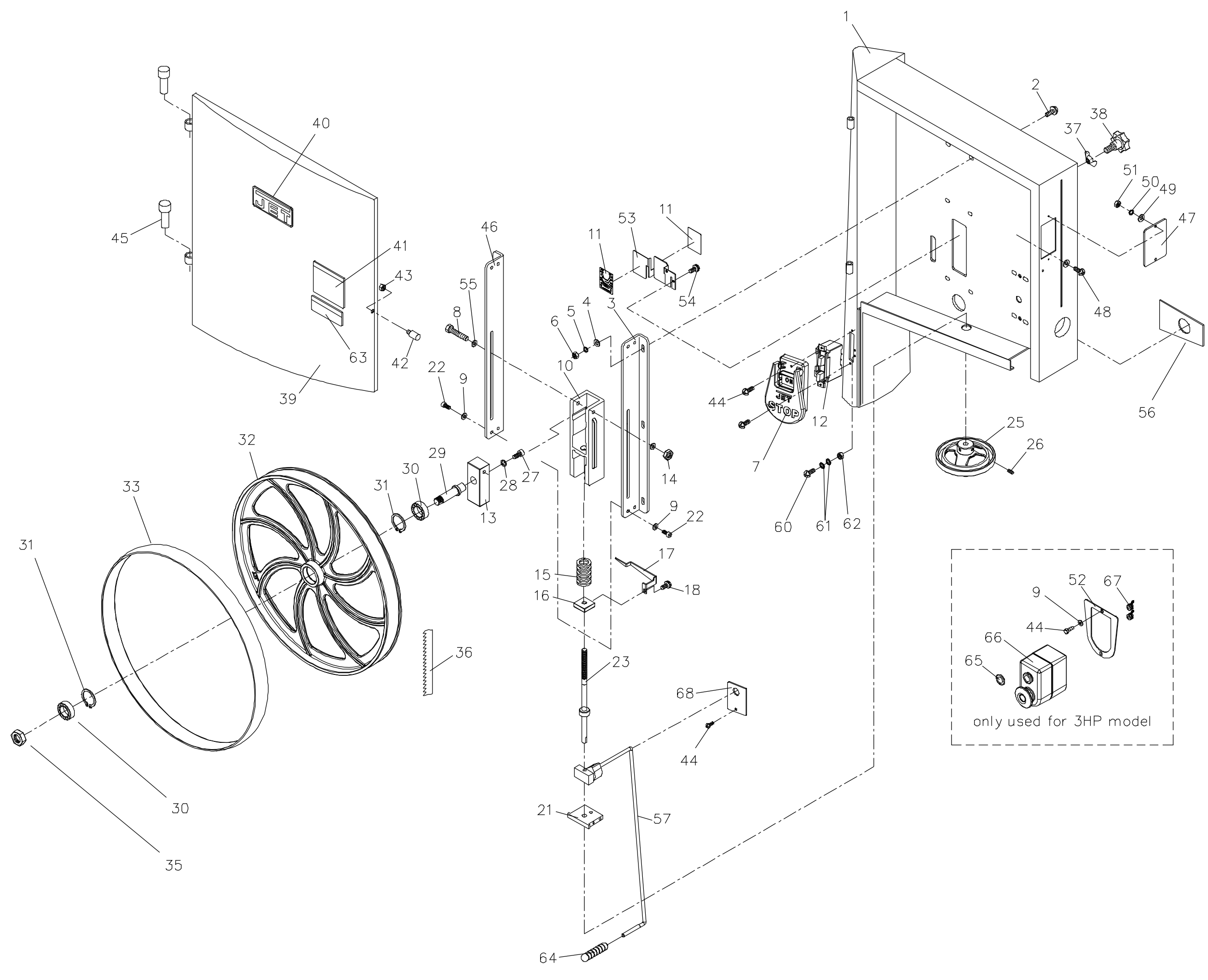
Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848, Monday through Friday (see our website for business hours, www.jettools.com). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Upper Wheel Assembly (18QT)

Index No.	Part No.	Description	Size	Qty
1	JWBS18DXA-101A	Saw Body		1
2	TS-0152011	Carriage Bolt	5/16-18 x 1	6
3	JWBS18DXA-103	Upper Wheel Bracket, Right Side		1
4	TS-0680031	Flat Washer	5/16	6
5	TS-0720081	Lock Washer	5/16	6
6	TS-0561021	Hex Nut	5/16-18	6
7	JPS10TS-342	Stop Switch Face Plate	for 1.75 HP	1
8	TS-1490151	Hex Cap Screw	M8x80	1
9	TS-0680021	Flat Washer	1/4	6
10	JWBS18DX-110	Sliding Bracket		1
11	JWBS18DX-111	Blade Tension Indicator Label		2
12	JPS10TS-343	Main Switch	for 1.75HP	1
13	JWBS18DX-113	Shaft Bracket		1
14	TS-1541031	Nylon Insert Lock Nut	M8	1
15	JWBS18DXA-115	Spring		1
16	JWBS18-116	Square Nut		1
17	JWBS18DX-117	Pointer		1
18	JWBS18-118	Screw	M5x8	1
21	JWBS18DXA-121	Bracket		1
22	TS-0050021	Hex Cap Screw	1/4-20 x 5/8	4
23	JWBS18DX-123	Blade Adjusting Screw		1
25	JWBS18-125	Hand Wheel		1
26	TS-0267041	Set Screw	1/4-20 x 3/8	2
27	TS-0209021	Socket Head Cap Screw	3/8-16 x 5/8	1
28	TS-0720091	Lock Washer	3/8	1
29	JWBS18-129	Upper Wheel Shaft		1
30	BB-6203ZZ	Ball Bearing	6203ZZ	2
31	JWBS18-131	Retaining Ring	R40	2
32	JWBS18-132	Upper Wheel		1
33	JWBS18DX-133	Tire		1
35	JWBS18-135	Hex Nut	5/8-18UNF L.H.	1
36	JWBS18DX-136	Blade	3/4"W x 137"L x .026T x 4TPI	1
37	TS-0590061	Wing Nut	5/16-18	1
38	JWBS18-138	Lock Knob	5/16	1
39	JWBS18DXA-139	Upper Front Door		1
	JWBS18-139A	Seal Strip, 29.92"L (not shown)	cut to fit 19.68"	1
40	JWBS18-140	JET Nameplate		1
41	JWBS18-141	Warning Label		1
42	JWBS18-142	Bolt		1
43	TS-0561011	Hex Nut	1/4-20	1
44	TS-081C052	Screw	#10-24 x 3/4	3
44A	TS-0050011	Hex Cap Screw	1/4-20 x 1/2	2
45	JWBS18-39A	Door Hinge Pin		2
46	JWBS18DXA-146	Upper Wheel Bracket, Left Side		1
47	JWBS18DX-147	Tracking Window		1
48	TS-081C032	Screw	#10-24 x 1/2	2
49	TS-1550031	Flat Washer	M5	4
50	TS-2361051	Lock Washer	M5	2
51	TS-0560071	Hex Nut	#10-24	2
52	JWBS18DXA-152A	Switch Plate	for 1.75HP	1
	JWBS18DXA-152	Switch Plate	for 3HP	1
53	JWBS18DX-153	Scale Bracket		1
54	TS-081C022	Screw	#10-24 x 3/8	2
55	TS-1550061	Flat Washer	M8	2
56	JWBS18DXA-156	Tension Status Label		1
57	JWBS18DXA-157	Blade Tension Arm Assembly		1

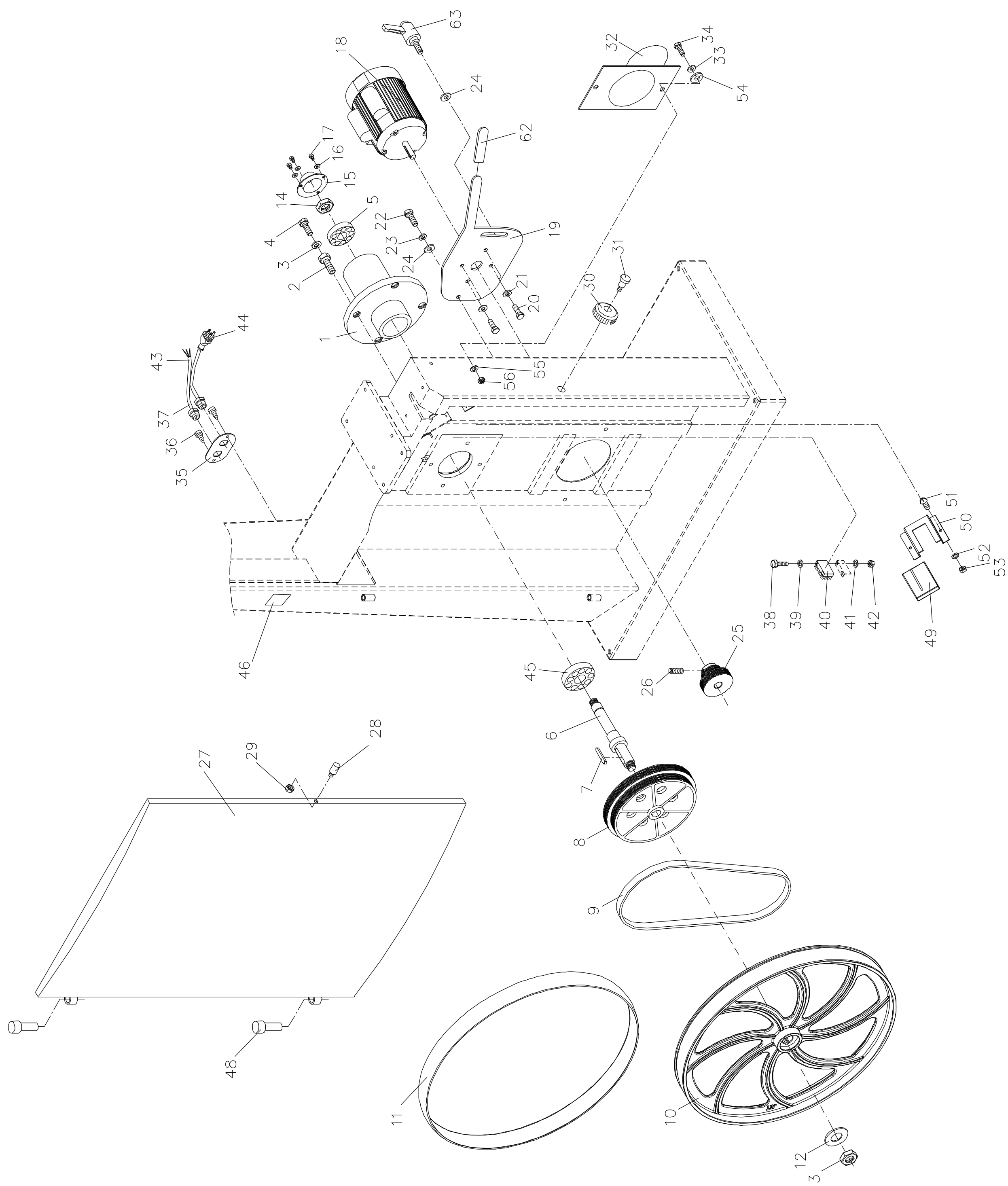
Index No.	Part No.	Description	Size	Qty
60	TS-1533052	Screw	M5 x 16	1
61	JWL1220VS-146	Star Washer	M5	1
62	TS-1540031	Hex Nut	M5	1
63	JWBS18DXA-163	Blade Warning Label		1
64	JWBS18DXA-164	Grip		1
65	PM2000-298	Safety Key for Magnetic Switch	for 3HP	1
66	PM2000-293	Magnetic Switch	for 3HP	1
67	PM2000-294	Strain Relief	for 3HP	2
68	JWBS18DXA-168	Spring Plate		1



Lower Wheel and Motor Assembly (18QT)

Index No.	Part No.	Description	Size	Qty
1	JWBS18-201N	Bearing Base		1
2	JWBS20-62	Adjusting Bolt		4
3	TS-0720091	Lock Washer	3/8	4
4	TS-0060081	Hex Cap Screw	3/8-16 x 1-3/4	4
5	BB-6204ZZ	Ball Bearing	6204ZZ	2
6	JWBS18DXA-206	Spindle		1
7	JWBS18-207	Key	7 x 7 x 40	1
8	JWBS18DXA-208	Spindle Pulley		1
9	JWBS18DXA-209	Poly V-Belt	440J	1
10	JWBS18-210	Lower Wheel		1
11	JWBS18DX-133	Tire		1
12	TS-0680081	Flat Washer	5/8.	1
13	JWBS18-135	Hex Nut	5/8-18UNF L.H.	1
14	JWBS18-214	Hex Nut	5/8-18UNF R.H.	1
15	JWBS18-215	Bearing Cover		1
16	TS-0720051	Lock Washer	#10	3
17	TS-081C022	Screw	#10-24 x 3/8	3
18	JWBS18DX-218	Motor	1.75HP, 1Ph, 115/230V (prewired 115V)	1
	JWBS18DX-218A	Motor	3HP, 1Ph, 230V	1
	JWBS18X-MFC	Motor Fan Cover (not shown)		1
19	JWBS18DXA-219	Motor Bracket		1
20	TS-0081031	Hex Cap Screw	5/16-18 x 3/4	4
21	TS-0680031	Flat Washer	5/16	4
22	TS-0060051	Hex Cap Screw	3/8-16 x 1	1
23	TS-0720091	Lock Washer	3/8	1
24	TS-0680041	Flat Washer	3/8	2
25	JWBS18DXA-225	Motor Pulley	for 1.75HP	1
	JWBS18DXA-225A	Motor Pulley	for 3HP	1
26	TS-0270031	Set Screw	5/16-18 x 3/8	2
27	JWBS18DXA-227	Lower Front Door		1
	JWBS18-139A	Seal Strip, 29.92”L (not shown)	29.92”	1
28	JWBS18-142	Bolt		1
29	TS-0561011	Hex Nut	1/4-20	1
30	JWBS20-2	Lock Knob		1
31	TS-081F052	Screw	1/4-20 x 3/4	1
32	JWBS20-8W	Dust Chute		1
33	TS-0680031	Flat Washer	5/16	2
34	TS-0051051	Hex Cap Screw	5/16-18 x 1	2
35	JWBS18-235	Plate		1
36	TS-081C032	Screw	#10-24 x 1/2	2
37	JWBS18-237	Strain Relief Bushing		2
38	TS-081C082	Screw	#10-24 x 1-1/2	2
39	TS-1550031	Flat Washer	M5	2
40	JWBS18-240	Brush		1
41	TS-2361051	Lock Washer	M5	2
42	TS-0560071	Hex Nut	#10-24	2
43	JWBS18-243	Motor Cord	for 1.75HP	1
	JWBS18DXA-243A	Motor Cord	for 3HP	1
44	JWBS18-244	Power Cord	for 1.75HP	1
	JWBS18DXA-244A	Power Cord	for 3HP	1
45	BB-6205ZZ	Ball Bearing	6205ZZ	1
46	JWBS18DXA-246	I.D. Label	1.75HP	1
	JWBS18DXA-246A	I.D. Label	3HP	1
48	JWBS18-39A	Door Hinge Pin		2
49	JWBS18DX-249	Bracket		1
50	JWBS18DX-250	Shelf		1
51	TS-081C032	Screw	#10-24 x 1/2	2

Index No.	Part No.	Description	Size	Qty
52	TS-1550031	Flat Washer	M5	2
53	TS-0560071	Hex Nut	#10-24	2
54	JWBS18DX-254	Plastic Washer	5/16	1
55	TS-0720081	Lock Washer	5/16	2
56	TS-0561021	Hex Nut	5/16-18	2
62	JWBS18DXA-262	Grip		1
63	JWBS18DXA-263	Lock Handle		1



Blade Guide Assembly (18QT)

Index No.	Part No.	Description	Size	Qty
1	TS-0051051	Hex Cap Screw	5/16-18 x 1	4
2	TS-0720081	Lock Washer	5/16	4
3	TS-0680031	Flat Washer	5/16	8
4	JWBS18DX-304	Guide Bar Bracket		1
5	JWBS18-305	Worm		1
6	JWBS18-306	E-Ring	E-8	2
7	JWBS18-307	Gear Base		1
8	JWBS18-308	Bushing		1
9	JWBS18-309	C-Ring	S-12	2
10	JWBS18-310	Shaft		1
11	JWBS18-311	Gear		1
12	TS-0208071	Socket Head Cap Screw	5/16-18 x 1-1/4	2
13	JWBS18-313	Lock Knob	5/16	1
14	JWBS18DX-314	Plate		1
15	TS-0255021	Button Head Socket Screw	5/16-18 x 1/2	4
16	JWBS18DX-316	Guide Bar		1
17	JWBS18DX-317	Pointer		1
18	TS-0720071	Lock Washer	1/4	3
19	TS-0050011	Hex Cap Screw	1/4-20 x 1/2	1
20	JWBS18-320N	Guide Bracket		1
21	TS-0207021	Socket Head Cap Screw	1/4-20 x 1/2	2
22	JWBS18X-322	Blade Guard		2
23	TS-0720111	Lock Washer	1/2	1
24	TS-0561051	Hex Nut	1/2-13	1
25	JWBS18DX-325	Locking Shaft		1
26	JWBS20-326	C-Ring		10
27	BB-6202ZZ	Ball Bearing	6202ZZ	10
28	JWBS20-328	Spacer		4
29	JWBS20-329	Shaft		2
30	TS-0270031	Set Screw	5/16-18 x 3/8	2
31	JWBS20-2	Lock Knob		1
32	TS-081F052	Screw	1/4-20 x 3/4	1
33	JWBS18-333	Hand Wheel		1
34	TS-0267041	Set Screw	1/4-20 x 3/8	1
35	JWBS20-103A	Handle		1
36	JWBS18DX-336	Cutting Height Scale		1
37	JWBS18DX-337	Bracket		1
38	JWBS18DX-338	Base		1
39	JWBS20-339	Threaded Lock Bushing		1
40	JWBS20-340	Bolt		1
41	JWBS18DX-341	Lock Knob		1
42	JWBS20-342	Screw		2
44	TS-0207041	Socket Head Cap Screw	1/4-20 x 3/4	2
45	TS-0680021	Flat Washer	1/4	2
46	JWBS20-360	Bracket		1
47	JWBS20-324	Wing Screw		2
48	TS-1521011	Set Screw	M4 x 4	8
49	JWBS20-349	Knob		2
50	TS-0207031	Socket Head Cap Screw	1/4-20 x 5/8	2
51	TS-0207021	Socket Head Cap Screw	1/4-20 x 1/2	2
52	JWBS20-352	Bracket		1
53	JWBS18DXA-353	Wing Screw	1/4-20 x 1/2	2
54	JWBS20-354	Bearing Support		2
55	JWBS20-355	Lock Bushing		1
56	TS-0206021	Socket Head Cap Screw	#10-24 x 1/2	2
57	JWBS18DX-357	Bearing Bracket		1
58	6295293	Locking Handle		1

Index No.	Part No.	Description	Size	Qty
59	JWBS18DX-359	Locking Handle		1
60	JWBS18DX-360	Shaft		1
61	JWBS18DX-361	Adjusting Screw		1
62	JWBS18DX-362	Adjusting Bracket		1
63	JWBS18DX-363	Nut		1
64	TS-0267021	Set Screw	1/4-20 x 1/4	1
65	JWBS18DX-365	Set Screw, Special		1
66	JWBS18DX-366	Adjustment Handle		2
67	TS-0680031	Flat Washer	5/16	1
68	JWBS20-329A	Lower Shaft		2
69	TS-0561011	Hex Nut	1/4-20	1
70	TS-081F032	Pan Head Screw	1/4-20 x 1/2	2

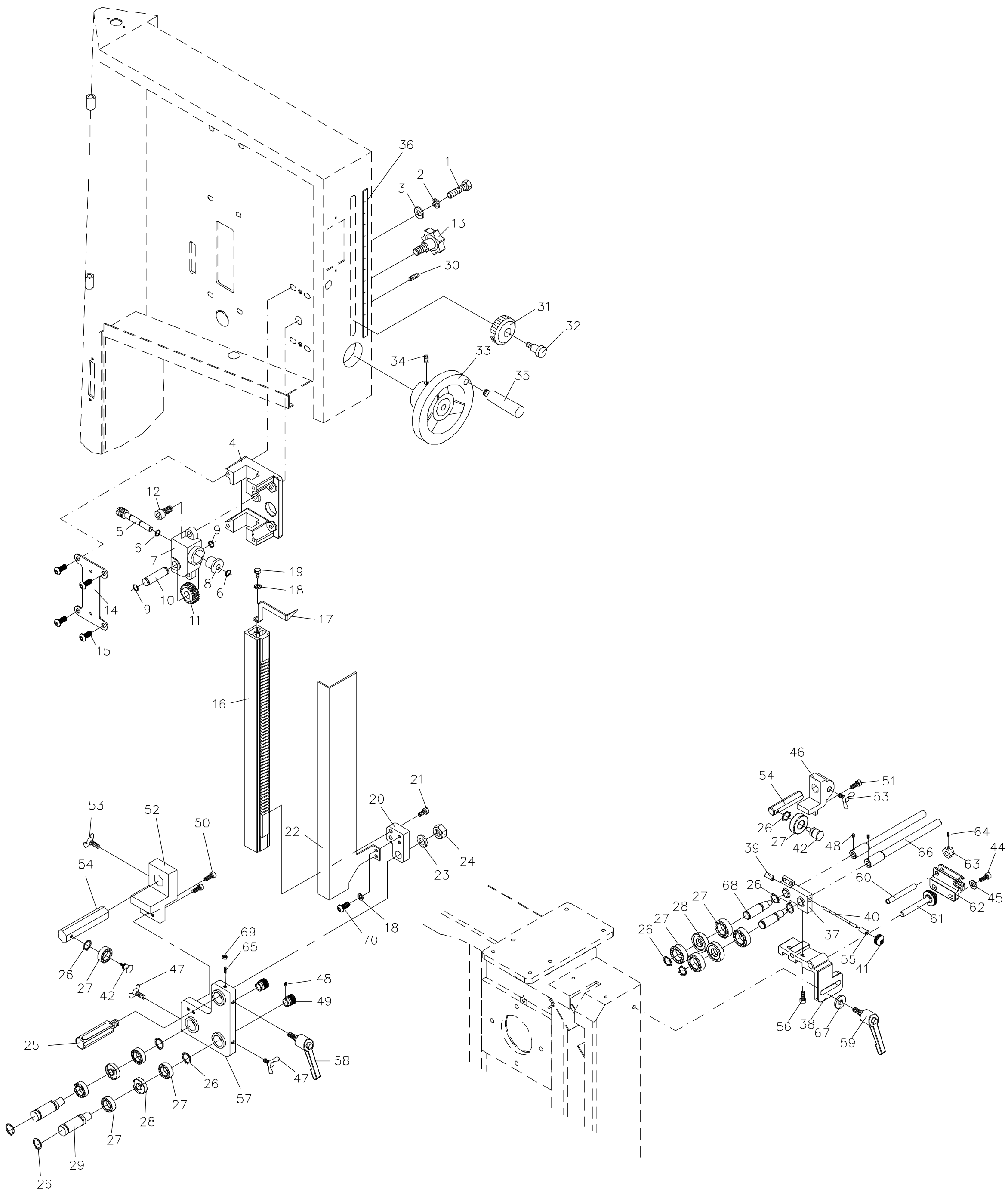
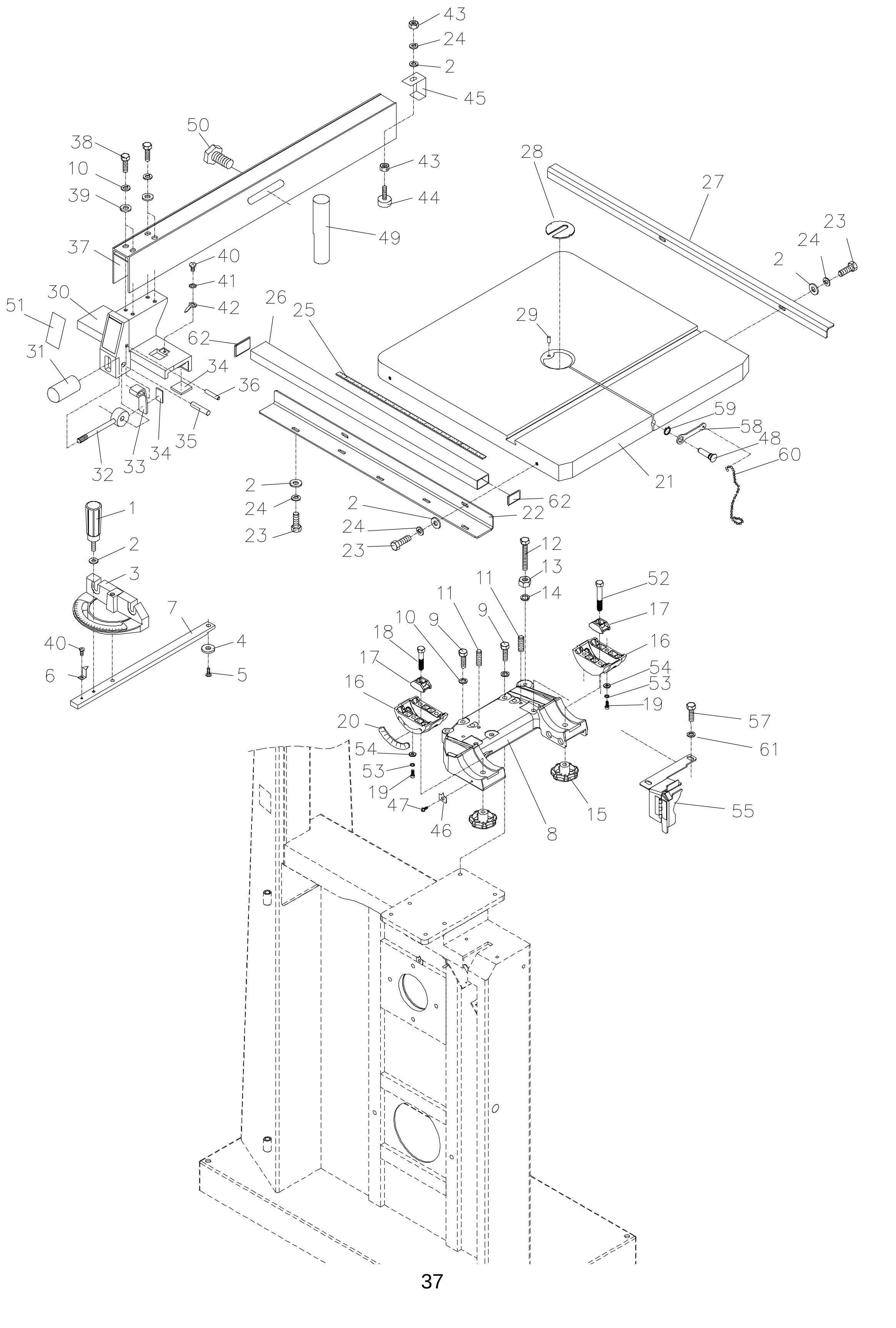


Table and Fence Assembly (18QT)

Index No.	Part No.	Description	Size	Qty
1	JWBS18-401	Lock Handle		1
2	TS-0680021	Flat Washer	1/4	11
3	JWBS18-403	Miter Gauge Body		1
4	JWBS20-156	Guide Disc		1
5	JWBS18-405	Screw	M6 x 8	1
6	JWBS18-406	Pointer		1
7	JWBS18-407	Guide Bar		1
8	JWBS18DX-408	Trunnion Support Bracket		1
9	TS-0051071	Hex Cap Screw	5/16-18 x 1-1/2	4
10	TS-0720081	Lock Washer	5/16	8
11	TS-0270061	Set Screw	5/16-18 x 5/8	2
12	TS-0060111	Hex Cap Screw	3/8-16 x 2-1/2	1
13	TS-0561031	Hex Nut	3/8-16	1
14	TS-0720091	Lock Washer	3/8	1
15	JWBS18-415	Lock Knob		2
16	JWBS18X-416	Trunnion		2
17	JWBS18-417	Trunnion Clamp Shoe		2
18	TS-1491081	Hex Cap Screw	M10 x 50	1
19	TS-1503041	Socket Head Cap Screw	M6 x 16	6
20	JWBS18-420	Scale		1
21	JWBS18-421	Table		1
22	JWBS18-422W	Front Rail		1
23	TS-0050021	Hex Cap Screw	1/4-20 x 5/8	9
24	TS-0720071	Lock Washer	1/4	10
25	JWBS18-425	Scale		1
26	JWBS18-426W	Guide Rail		1
27	JWBS18-427W	Rear Rail		1
28	JWBS20-144	Table Insert		1
29	JWBS20-145	Roll Pin	3 x 10	1
30	JWBS18-430	Fence Body		1
31	JWBS18-431	Knob		1
32	JWBS18-432	Lock Handle		1
33	JWBS18-433W	Lock Plate		1
34	JWBS18-434	Pad		5
35	JWBS18-435	Pin		1
36	JWBS18-436	Pin		1
37	JWBS18-437EA	Fence		1
38	TS-0208041	Socket Head Cap Screw	5/16-18 x 3/4	4
39	TS-0680031	Flat Washer	5/16	4
40	TS-0810012	Screw	#10-24 x 1/4	2
41	TS-0733031	External Tooth Lock Washer	#10	1
42	JWBS18-442	Pointer		1
43	TS-0561011	Hex Nut	1/4-20	2
44	JWBS18-444	Sliding Pad		1
45	JWBS18-445	Rear Hook		1
46	JWBS18-446	Pointer		1
47	JWBS18-447	Screw	M5 x 8	1
48	JWBS18DX-448	Table Pin		1
49	JWBS18-449E	Resaw Post		1
50	JWBS18-450	Lock Knob		1
51	JWBS18-451	JET Fence Label		1
52	TS-2210651	Hex Cap Screw	M10 x 65	1
53	TS-1551041	Lock Washer	M6	6
54	TS-1550041	Flat Washer	M6	6
55	JWBS18DX-455	Lower Blade Guard		1
57	TS-0051091	Hex Cap Screw	5/16-18 x 2	2
58	40-0260	Wrench		1

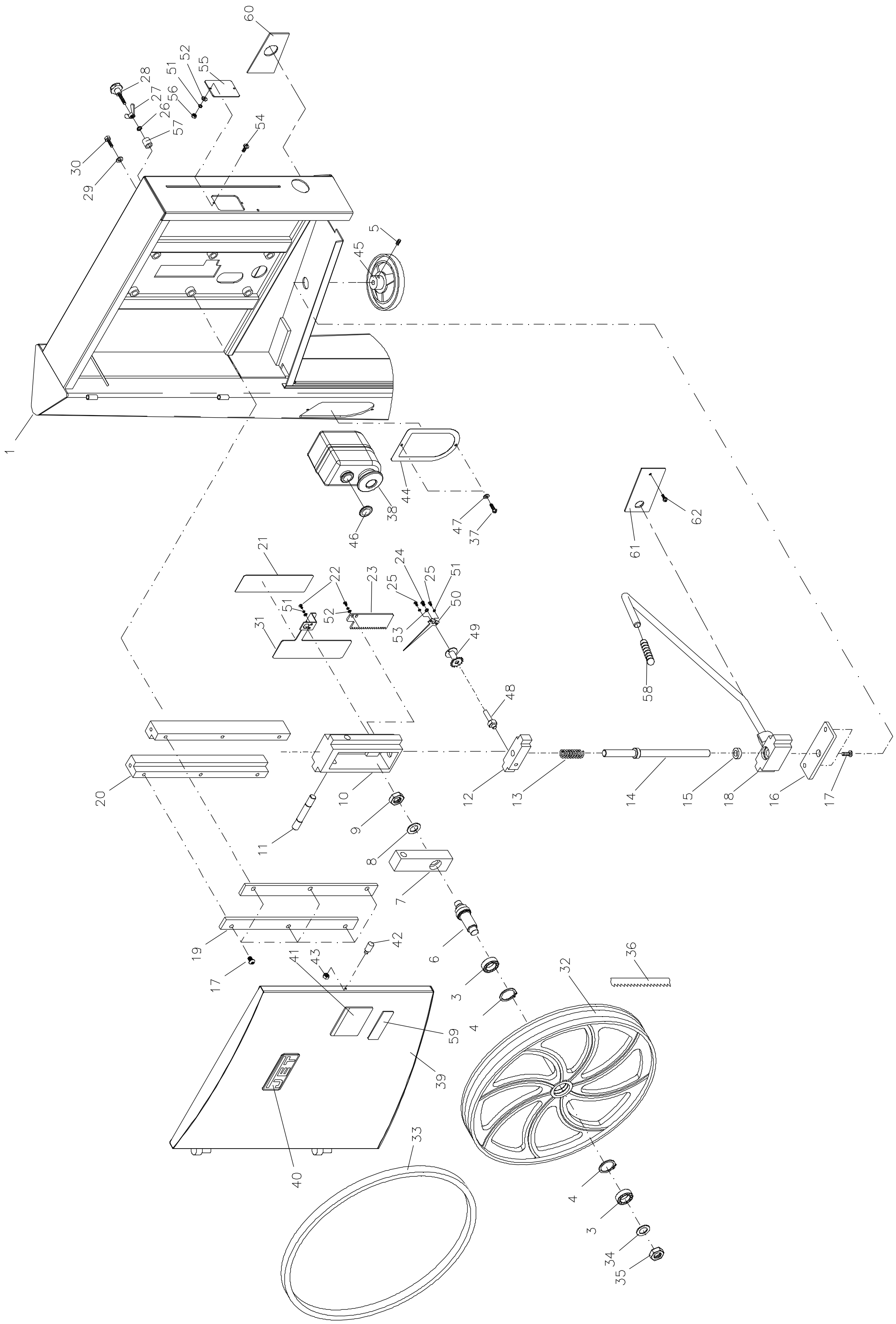
Index No.	Part No.	Description	Size	Qty
59	JWBS18DX-459	C-Ring	S-10	1
60	JWBS18DX-460	Link Chain		1
61	TS-0680031	Flat Washer	5/16	2
62	2013-285	End Cover		2
	JWBS18-MGCP	Miter Gauge Assembly		1
	JWBS18QT-FCP	Fence Assembly		1



Upper Wheel Assembly (20QT)

Index No.	Part No.	Description	Size	Qty
1	JWBS20QT-501	Saw Body	for 3HP	1
	JWBS20QT-501A	Saw Body	for 5HP	1
3	BB-6205ZZ	Ball Bearing	6205	2
4	JWBS20QT-504	Retaining Ring	R52	2
5	TS-0270051	Set Screw	5/16-18x1/2	1
6	JWBS20QT-506	Upper Wheel Shaft		1
7	JWBS20QT-507	Upper Wheel Shaft Bracket		1
8	TS-155010	Flat Washer	M16	1
9	JWBS18-214	Hex Nut	5/8-18 UNF R.H.	1
10	JWBS20QT-510	Upper Wheel Bracket Base		1
11	JWBS20QT-511	Bracket Shaft		1
12	JWBS20QT-512	Elevator Bracket		1
13	JWBS20QT-513	Spring		1
14	JWBS20QT-514	Adjustment Screw		1
15	JWBS20QT-515	Thrust Bearing		1
16	JWBS20QT-516	Plate		1
17	TS-0256051	Button Head Socket Screw	3/8-16x1	8
18	JWBS20QT-518	Blade Tension Arm Assembly		1
19	JWBS20QT-519	Plate		2
20	JWBS20QT-520	Support Bracket		2
21	JWBS20QT-521	Blade Width/Tension Scale		1
22	TS-0206021	Socket Head Cap Screw	#10-24x1/2	4
23	JWBS20QT-523	Rack		1
24	TS-0254031	Button Head Socket Screw	1/4-20x5/8	1
25	TS-081C022	Pan Head Machine Screw	#10-24x3/8	2
26	TS-0720091	Lock Washer	3/8	1
27	JWBS20QT-527	Wing Nut	3/8	1
28	JWBS20QT-528	Lock Knob		1
29	TS-0680041	Flat Washer	3/8	6
30	TS-0060061	Hex Cap Screw	3/8-16x1-1/4	6
31	JWBS20QT-531	Blade Width Gauge Plate		1
32	JWBS20QT-532	Upper Wheel		1
33	JWBS20-21	Tire		1
34	TS-0680091	Flat Washer	3/4	1
35	JWBS20-22	Hex Nut	3/4-16UNF L.H.	1
36	JWBS20QT-536	Blade	150”L x 1”W x 0.028”T x 3TPI	1
37	TS-0050011	Hex Cap Screw	1/4-20x1/2	2
38	PM2000-293	Magnetic Switch	3HP, 1Ph	1
	PM2000-293A	Magnetic Switch	5HP, 1Ph	1
39	JWBS20QT-539	Upper Front Door		1
	JWBS18-139A	Seal Strip, 29.92”L (not shown)	cut to fit 21.26”	1
40	JWBS18-140	JET Plaque		1
41	JWBS18-141	Warning Label		1
42	JWBS20-542	Door Stud		1
43	TS-0561011	Hex Nut	1/4x20	1
44	JWBS18DXA-152	Switch Plate		1
45	JWBS20QT-545	Hand Wheel		1
46	PM2000-298	Safety Key for Magnetic Switch		1
47	TS-0680021	Flat Washer	1/4	2
48	JWBS20QT-548	Scale Shaft		1
49	JWBS20QT-549	Gear Wheel		1
50	JWBS20QT-550	Pointer		1
51	TS-0720051	Lock Washer	#10	8
52	TS-069204	Flat Washer	#10	6
53	TS-0720071	Lock Washer	1/4	2
54	TS-081C032	Pan Head Machine Screw	#10-24x1/2	2
55	JWBS18DX-147	Tracking Window		1

Index No.	Part No.	Description	Size	Qty
56	TS-0560071	Hex Nut	#10-24	2
57	2013-333	Spacer		1
58	JWBS18DXA-164	Grip		1
59	JWBS18DXA-163	Blade Warning Label		1
60	JWBS20QT-560	Tension Status Label		1
61	JWBS18DXA-168	Spring Plate		1
62	TS-081C052	Screw	#10-24 x 3/4	1

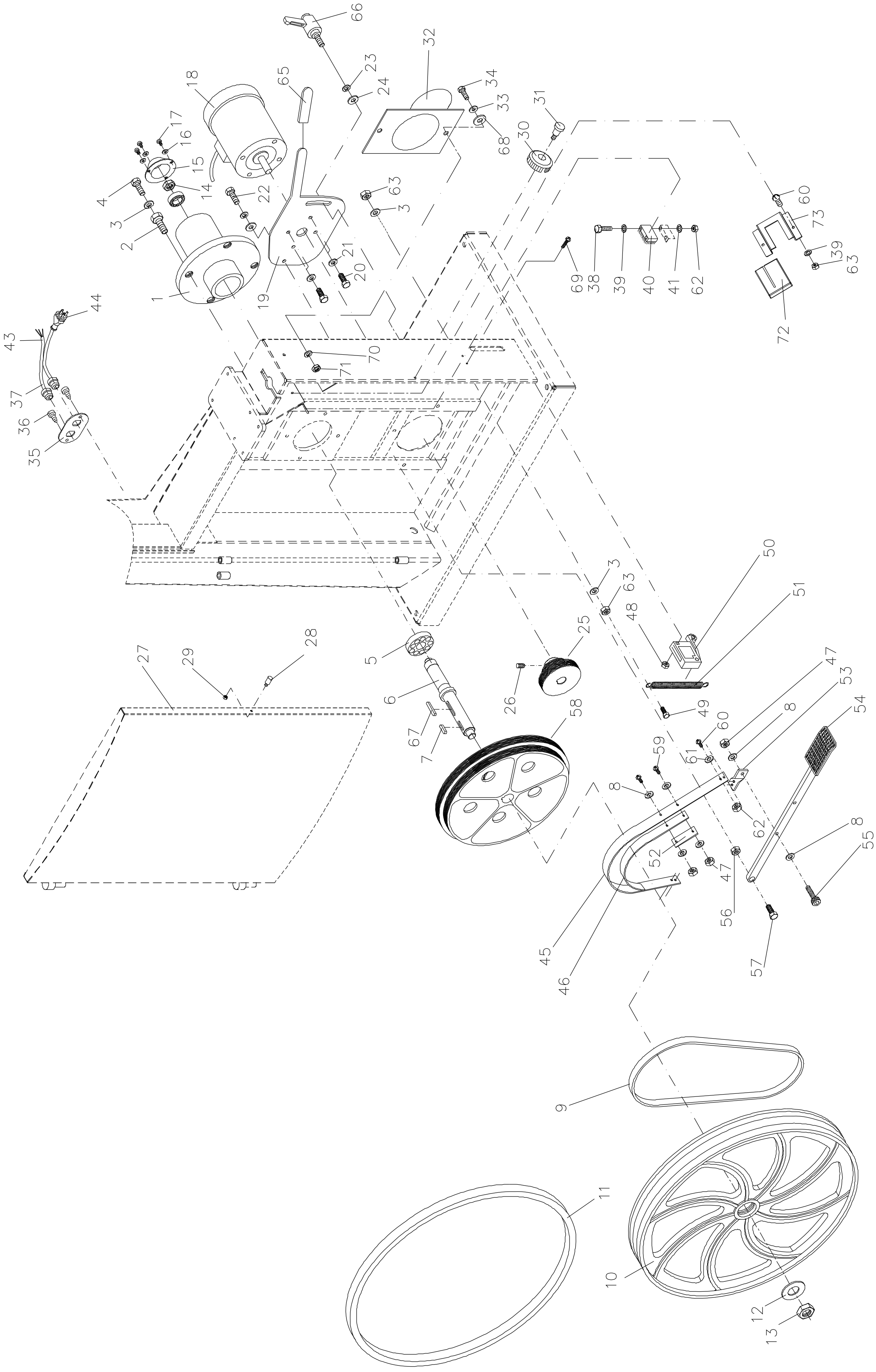


Lower Wheel and Motor Assembly (20QT)

Index No.	Part No.	Description	Size	Qty
1	JWBS20-201	Bearing Base		1
2	JWBS20-62	Adjusting Bolt		4
3	TS-0720091	Lock Washer	3/8	6
4	TS-0060111	Hex Cap Screw	3/8x2-1/2	4
5	BB-6206ZZ	Ball Bearing	6206	2
6	JWBS20QT-206	Spindle		1
7	JWBS20-49	Key	7x7x25	1
8	TS-0680021	Flat Washer	1/4	12
9	JWBS20QT-209	V-Belt	520J	1
10	JWBS20-532	Lower Wheel		1
11	JWBS20-21	Tire		1
12	TS-0680091	Flat Washer	3/4	1
13	JWBS20-22	Hex Nut	3/4-16UNF L.H	1
14	JWBS20-214	Hex Nut	3/4-16UNF R.H	1
15	JWBS20-215	Bearing Cover		1
16	TS-0720071	Lock Washer	1/4	3
17	JWBS20-217	Screw	1/4x3/8	3
18	JWBS18DX-218A	Motor	3HP, 1Ph, 230V Only	1
	JWBS18DX-218ASC	Starting Capacitor (not shown)	300MFD, 125VAC	1
	JWBS18DX-218ARC	Running Capacitor (not shown)	60µf, 250VAC	1
	JWBS18DX-218ACC	Capacitor Cover (not shown)		1
	VBS18MW-218JB	Junction Box (not shown)		1
	VBS18MW-218JBC	Junction Box Cover (not shown)		1
	JWBS20-218E	Motor Fan (not shown)		1
	JWBS20-218F	Motor Fan Cover (not shown)		1
	JWBS20-218G	Centrifugal Switch (not shown)		1
	JWBS20QT-218	Motor	5HP, 1Ph, 230V	1
	JWBS20QT-218MF	Motor Fan (not shown)	5HP	1
	JWBS20QT-218MFC	Motor Fan Cover (not shown)	5HP	1
	JWBS20QT-218SC	Starting Capacitor (not shown)	300MFD, 250VAC	1
	JWBS20QT-218RC	Running Capacitor (not shown)	50µf, 450VAC	1
	JWBS20QT-218CC	Capacitor Cover (not shown)		1
	JWBS20QT-218JB	Junction Box (not shown)		1
	VBS18MW-218JBC	Junction Box Cover (not shown)		1
	JWBS20QT-218CS	Centrifugal Switch (not shown)		1
19	JWBS20QT-219	Motor Bracket		1
20	TS-0081031	Hex Cap Screw	5/16-18x3/4	4
21	TS-0680031	Flat Washer	5/16	4
22	TS-0060051	Hex Cap Screw	3/8-16x1	1
23	TS-0720091	Lock Washer	3/8	2
24	TS-0680041	Flat Washer	3/8	2
25	JWBS20QT-225	Motor Pulley		1
26	TS-0270031	Set Screw	5/16-18x3/8	2
27	JWBS20QT-227	Lower Front Door		1
	JWBS18-139A	Seal Strip, 29.92"L (not shown)	cut to fit 28.74"	1
28	JWBS20-542	Door Stud		1
29	TS-0561011	Hex Nut	1/4-20	1
30	JWBS20-2	Lock Knob		1
31	TS-081F052	Pan Head Machine Screw	1/4-20x3/4	1
32	JWBS20-8	Dust Chute		1
33	TS-0680031	Flat Washer	5/16	2
34	TS-0051051	Hex Cap Screw	5/16-18x1	2
35	JWBS20QT-235	Cord Plate	for 3HP	1
	PM1800-251	Cord Plate	for 5HP	1
36	TS-081C032	Pan Head Machine Screw	#10-24x1/2	2
37	JWBS18-237	Strain Relief Bushing	for 3HP	2
	JWBS20X-237A	Strain Relief Bushing	for 5HP	2

Index No.	Part No.	Description	Size	Qty
38	TS-081C082	Pan Head Machine Screw	#10-24x1-1/2	2
39	TS-069204	Flat Washer	#10	4
40	JWBS18-240	Brush		1
41	TS-0720051	Lock Washer	#10	2
43	JWBS18DX-243A	Motor Cord	for 3HP	1
	JWBS20QT-243	Motor Cord	for 5HP	1
44	JWBS18DX-244A	Power Cord	for 3HP	1
	JWBS20QT-244	Power Cord	for 5HP	1
45	JWBS20-81	Brake Band		1
46	JWBS20-93	Brake Belt		1
47	TS-0561011	Hex Nut	1/4-20	6
48	TS-1540021	Hex Nut	M4	2
49	TS-0060111	Hex Cap Screw	3/8-16x2-1/2	1
50	JWBS20-88	Brake Switch		1
51	JWBS20-84	Spring		1
52	JWBS24-81A	Plate		2
53	JWBS20-82	Brake Locking Bracket		2
54	JWBS20-254	Brake Pedal		1
55	TS-0207061	Socket Head Cap Screw	1/4-20x1	1
56	TS-0561031	Hex Nut	3/8-16	1
57	TS-0060081	Hex Cap Screw	3/8-16x1-3/4	1
58	JWBS20QT-258	Spindle Pulley		1
59	TS-0050021	Hex Cap Screw	1/4-20x5/8	2
60	TS-081C032	Pan Head Machine Screw	#10-24x1/2	6
61	TS-069204	Flat Washer	#10	4
62	TS-0560071	Hex Nut	#10-24	8
63	TS-0561031	Hex Nut	3/8-16	2
	JWBS20-264	Brake Switch Cord (not shown)		1
65	JWBS18DXA-262	Grip		1
66	JWBS18DXA-263	Lock Handle		1
67	JWBS20QT-267	Key	7x7x40	1
68	JWBS18DX-254	Plastic Washer		1
69	TS-2284302	Pan Head Machine Screw	M4x30	2
70	TS-0720081	Lock Washer	5/16	2
71	TS-0561021	Hex Nut	5/16-18	2
72	JWBS18DX-249	Bracket		1
73	JWBS18DX-250	Shelf		1

Lower Wheel and Motor Assembly (20QT)



Blade Guide Assembly (20QT)

Index No.	Part No.	Description	Size	Qty
1	TS-0051051	Hex Cap Screw	5/16-18x1	4
2	TS-0720081	Lock Washer	5/16	4
3	TS-0680031	Flat Washer	5/16	8
4	JWBS20-304	Guide Bar Bracket		1
5	JWBS18-305	Worm		1
6	JWBS18-306	E-Ring	E-8	2
7	JWBS18-307	Gear Base		1
8	JWBS18-308	Bushing		1
9	JWBS18-309	C-Ring	S-12	2
10	JWBS18-310	Shaft		1
11	JWBS18-311	Gear		1
12	TS-0208071	Socket Head Cap Screw	5/16-18x1-1/4	2
13	JWBS20-313	Lock Knob	5/16	1
14	JWBS20-314	Plate		1
15	TS-0051011	Hex Cap Screw	5/16-18x1/2	4
16	JWBS20-316	Guide Bar		1
17	JWBS20QT-317	Pointer		1
19	TS-0050011	Hex Cap Screw	1/4-20x1/2	1
20	JWBS20QT-320	Blade Guard		1
21	TS-0680021	Flat Washer	1/4	6
22	TS-0720071	Lock Washer	1/4	2
23	TS-0050021	Hex Cap Screw	1/4-20x5/8	2
24	JWBS20-324	Wing Bolt		2
25	JWBS18DX-325	Bracket Shaft		1
26	JWBS20-326	C-Ring		10
27	BB-6202ZZ	Ball Bearing	6202	10
28	JWBS20-328	Spacer		4
29	JWBS20-329	Upper Guide Shaft		2
30	TS-0267041	Set Screw	1/4-20x3/8	2
31	JWBS20-2	Lock Knob		1
32	TS-081F052	Pan Head Machine Screw	1/4-20x3/4	1
33	JWBS18-333	Hand Wheel		1
34	TS-0267041	Set Screw	1/4-20x3/8	1
35	JWBS20-103A	Handle		1
36	JWBS18DX-336	Cutting Height Scale		1
37	JWBS18DX-337	Bracket		1
38	JWBS18DX-338	Base		1
39	JWBS20-339	Threaded Lock Bushing		1
40	JWBS20-340	Bolt		1
41	JWBS18DX-341	Lock Knob		1
42	JWBS20-342	Screw		2
44	JWBS20-344	Guide Bar Bracket		1
45	TS-0270031	Set Screw	5/16-18x3/8	2
46	TS-0720111	Lock Washer	1/2	1
47	TS-0561051	Hex Nut	1/2-13	1
48	TS-1521011	Set Screw	M4x4	8
49	JWBS20-349	Thumb Screw		2
50	TS-0207031	Socket Head Cap Screw	1/4-20x5/8	3
51	TS-0207021	Socket Head Cap Screw	1/4-20x1/2	2
52	JWBS20-352	Bracket		1
53	JWBS18DXA-353	Thumb Screw	1/4-20x1/2	2
54	JWBS20-354	Bearing Support		2
55	JWBS20-355	Lock Bushing		1
56	TS-0720071	Lock Washer	1/4	1
57	TS-0206021	Socket Head Cap Screw	#10-24x1/2	2
58	JWBS18DX-357	Bearing Bracket		1
59	JWBS18DX-360	Shaft		1

Index No.	Part No.	Description	Size	Qty
60	JWBS20-360	Bracket		1
61	JWBS18DX-361	Adjusting Screw		1
62	JWBS18DX-362	Adjusting Bracket		1
63	JWBS18DX-363	Nut		1
64	TS-0267021	Set Screw	1/4-20x1/4	1
65	JWBS18DX-365	Set Screw, Special		1
66	JWBS18DX-366	Adjustment Handle		2
67	TS-0680031	Flat Washer	5/16	1
68	JWBS20-329A	Lower Guide Shaft		2
69	TS-0561011	Hex Nut	1/4-20	1
70	6295293	Locking Handle		1
71	JWBS18DX-359	Locking Handle		1
72	TS-0207041	Socket Head Cap Screw	1/4-20x3/4	2

Blade Guide Assembly

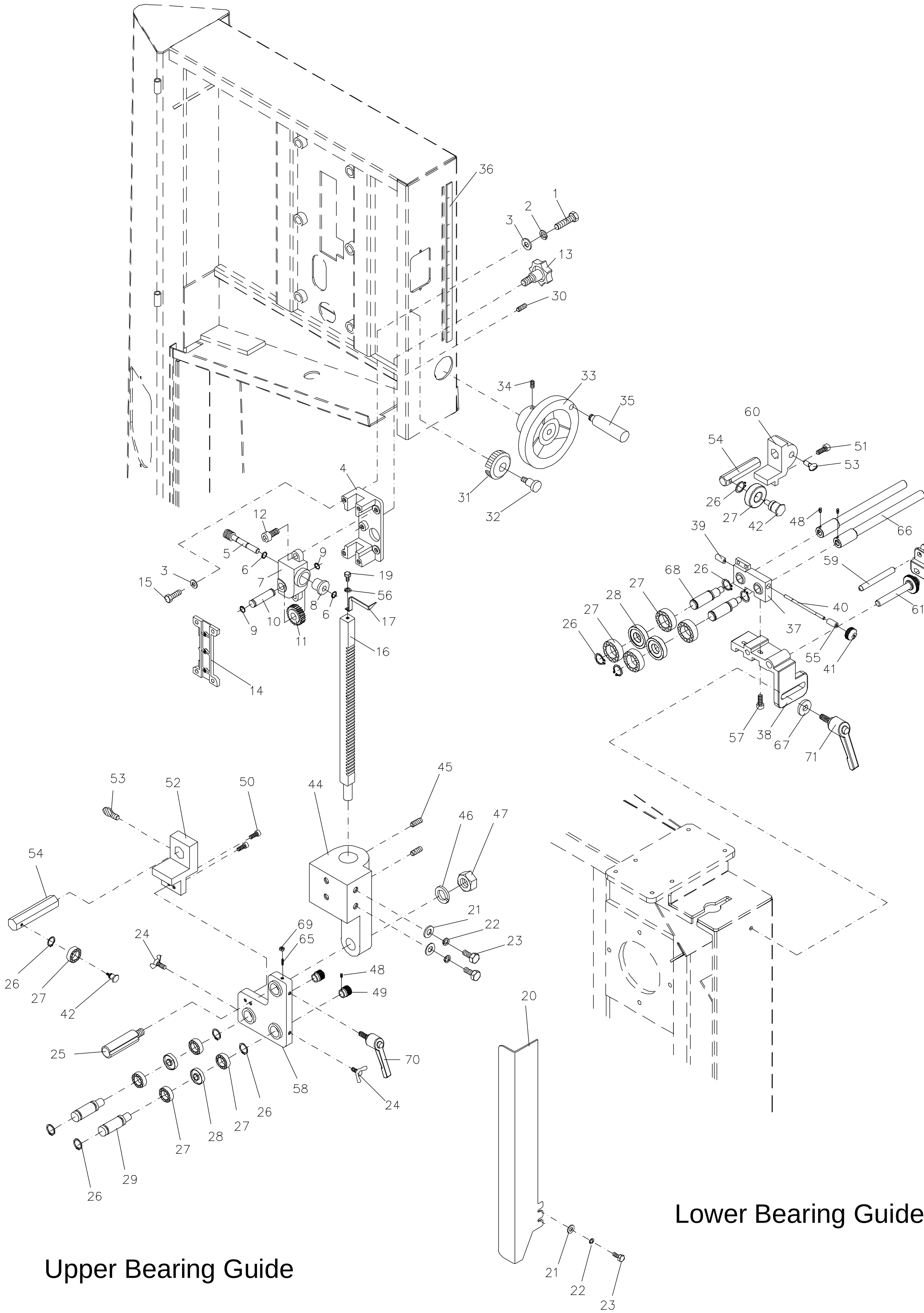
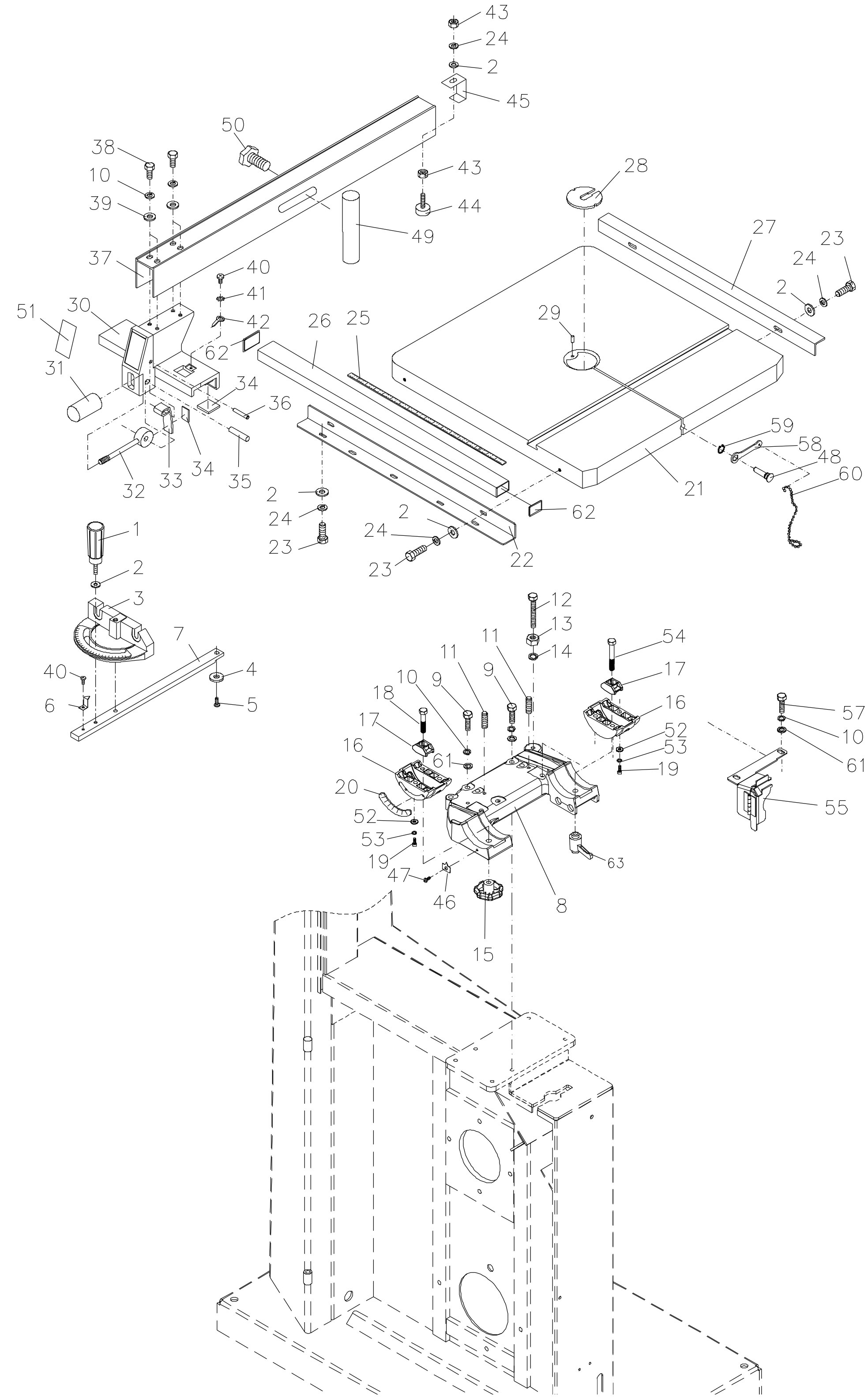


Table and Fence Assembly (20QT)

Index No.	Part No.	Description	Size	Qty
1	JWBS18-401	Locking Handle		1
2	TS-0680021	Flat Washer	1/4	11
3	JWBS18-403	Miter Gauge Body		1
4	JWBS20-156	Guide Disc		1
5	JWBS18-405	Screw	M6x8	1
6	JWBS18-406	Pointer		1
7	JWBS18-407	Guide Bar		1
8	JWBS18DX-408	Trunnion Support Bracket		1
9	TS-0051071	Hex Cap Screw	5/16-18x1-1/2	4
10	TS-0720081	Lock Washer	5/16	8
11	TS-0270061	Set Screw	5/16-18x5/8	2
12	TS-0060111	Hex Cap Screw	3/8-16x2-1/2	1
13	TS-0561031	Hex Nut	3/8-16	1
14	TS-0720091	Lock Washer	3/8	1
15	JWBS18-415	Lock Knob		2
16	JWBS18X-416	Trunnion		2
17	JWBS18-417	Trunnion Clamp Shoe		2
18	TS-1491081	Hex Cap Screw	M10x50	1
19	TS-1503041	Socket Head Cap Screw	M6x16	6
20	JWBS18-420	Scale		1
21	JWBS20-421	Table		1
22	JWBS18-422W	Front Rail		1
23	TS-0050021	Hex Cap Screw	1/4-20x5/8	9
24	TS-0720071	Lock Washer	1/4	10
25	JWBS18-425	Scale		1
26	JWBS20-426	Guide Rail		1
27	JWBS18-427W	Rear Rail		1
28	JWBS20-144	Table Insert		1
29	JWBS20-145	Roll Pin	3x10	1
30	JWBS18-430	Fence Body		1
31	JWBS18-431	Handle		1
32	JWBS18-432	Cam		1
33	JWBS18-433W	Lock Plate		1
34	JWBS18-434	Pad		5
35	JWBS18-435	Pin		1
36	JWBS18-436	Pin		1
37	JWBS20-437EA	Fence		1
38	TS-0208041	Socket Head Cap Screw	5/16-18x3/4	4
39	TS-0680031	Flat Washer	5/16	4
40	TS-0810012	Screw	#10-24x1/4	2
41	TS-0733031	External Tooth Lock Washer	#10	1
42	JWBS18-442	Pointer		1
43	TS-0561011	Hex Nut	1/4-20	2
44	JWBS18-444	Sliding Pad		1
45	JWBS18-445	Rear Hook		1
46	JWBS18-446	Pointer		1
47	JWBS18-447	Screw	M5x8	1
48	JWBS18DX-448	Table Pin		1
49	JWBS18-449E	Resaw Guide		1
50	JWBS20-450	Lock Knob		1
	JWBS18-MGCP	Miter Gauge Assembly		1
	JWBS20QT-FCP	Fence Assembly		1
51	JWBS18-451	JET Fence Label		1
52	TS-1550041	Flat Washer	M6	6
53	TS-1551041	Lock Washer	M6	6
54	TS-2210651	Hex Cap Screw	M10x65	1
55	JWBS18DX-455	Lower Blade Guard		1

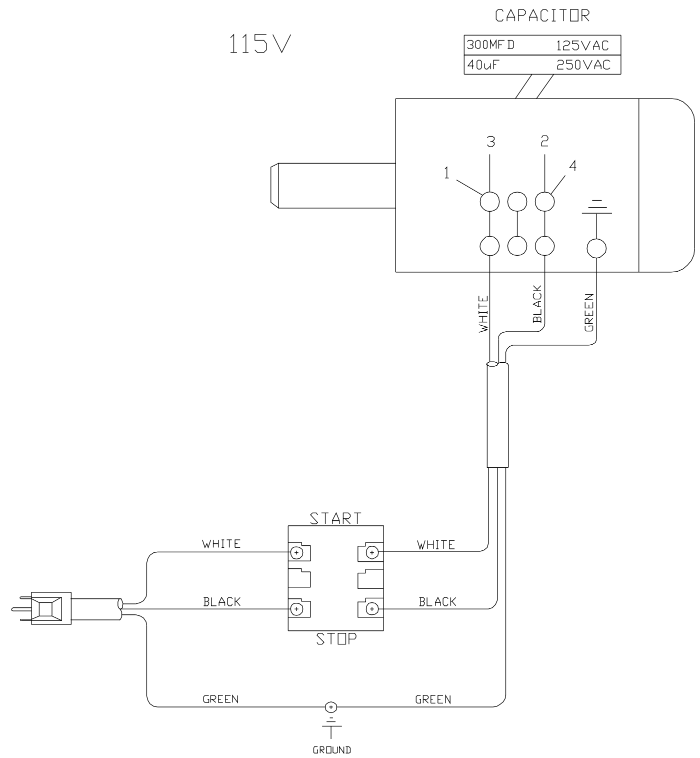
Index No.	Part No.	Description	Size	Qty
57	TS-0051091	Hex Cap Screw	5/16-18x2	2
58	40-0260	Wrench		1
59	JWBS18DX-459	C-Ring	S-10	1
60	JWBS18DX-460	Link Chain		1
61	TS-0680031	Flat Washer	5/16	6
62	2013-285	End Cover		2
63	JWBS20QT-463	Lock Handle		1



Electrical Connections

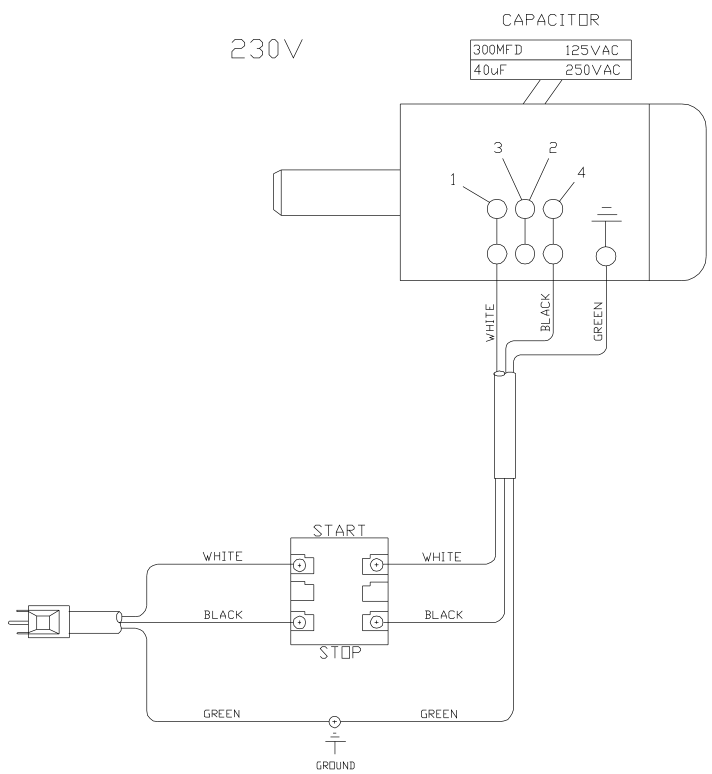
1 3/4 HP, 1Ph, 115V

Band Saw Model No.: JWBS-18QT-1 (SN 710750B)



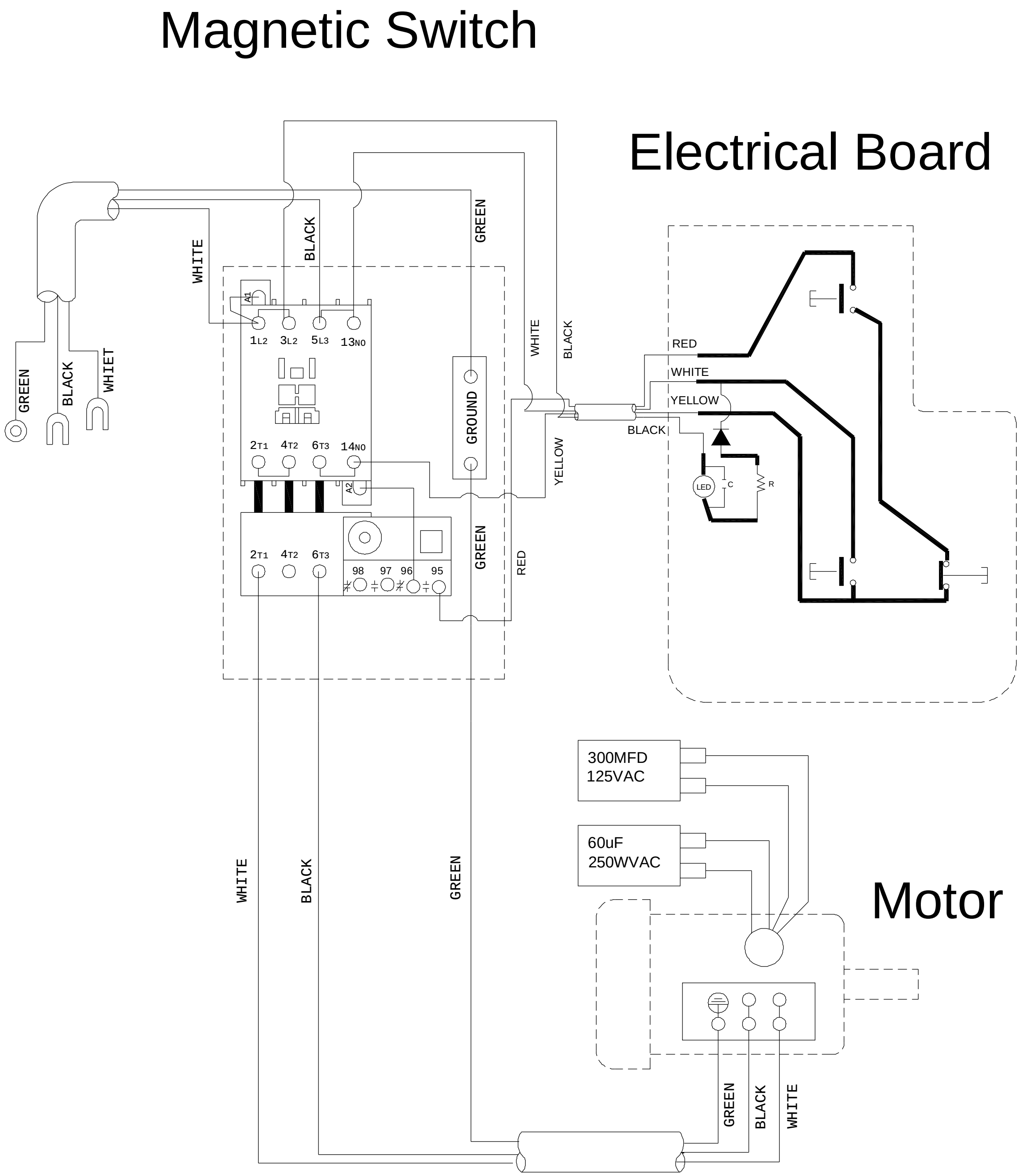
1-3/4 HP, 1Ph, 230V

Band Saw Model No.: JWBS-18QT-1 (SN 710750B)



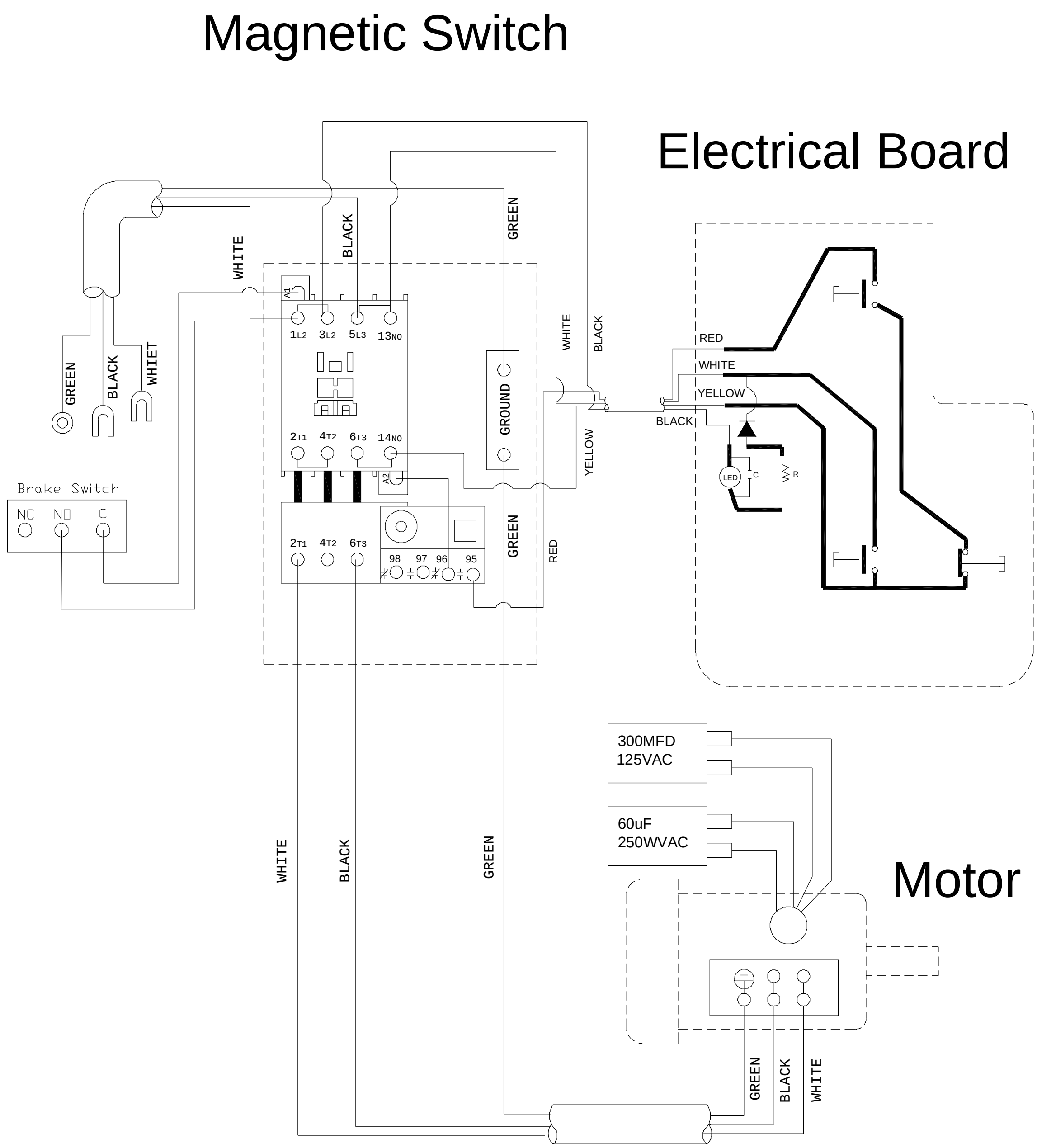
3 HP, 1Ph, 230V

Band Saw Model No.: JWBS-18QT-3 (SN 710751B)



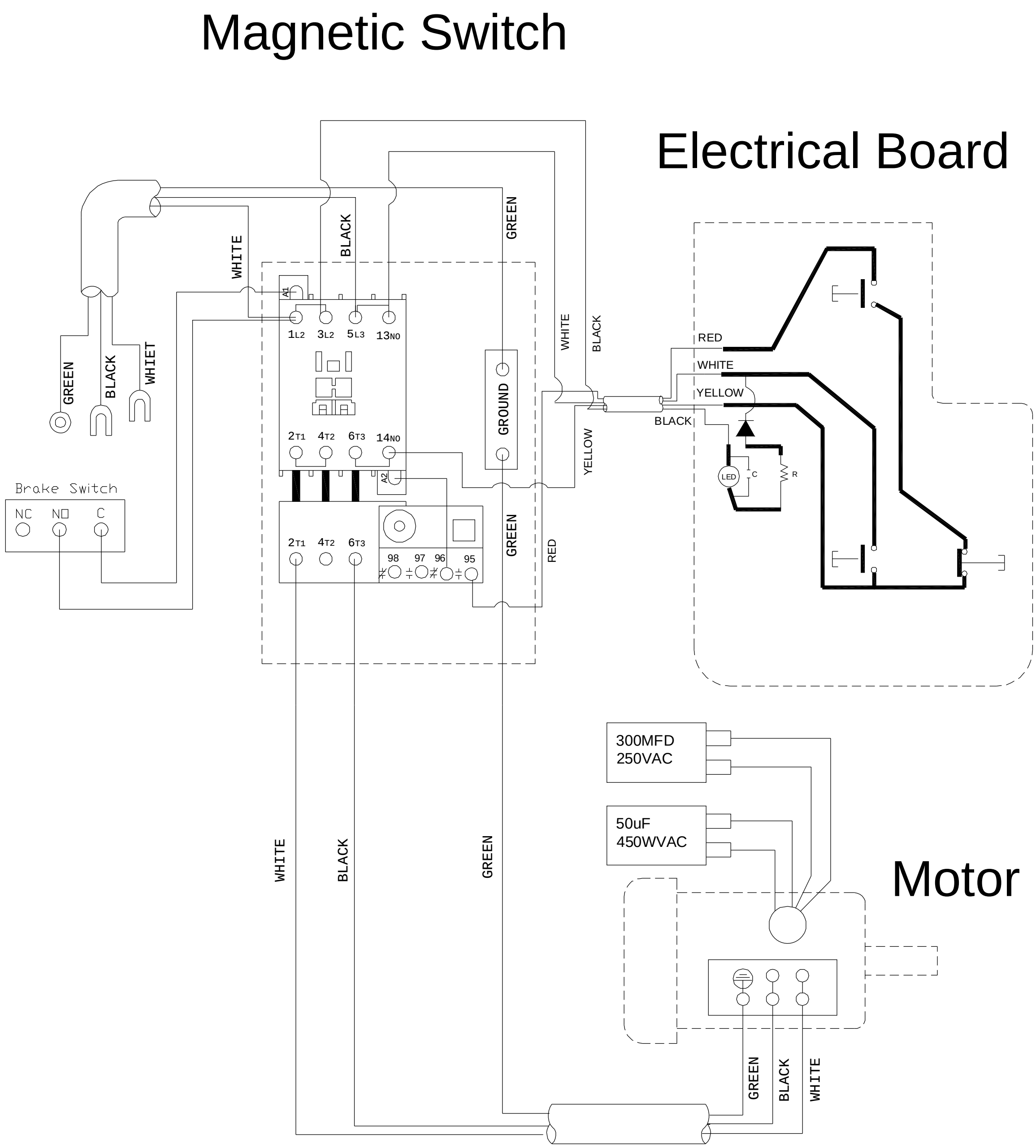
3 HP, 1Ph, 230V

Band Saw Model No.: JWBS-20QT-3 (SN708754B)



5 HP, 1Ph, 230V

(Band Saw Model No.: JWBS-20QT-5, SN 708755B)



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